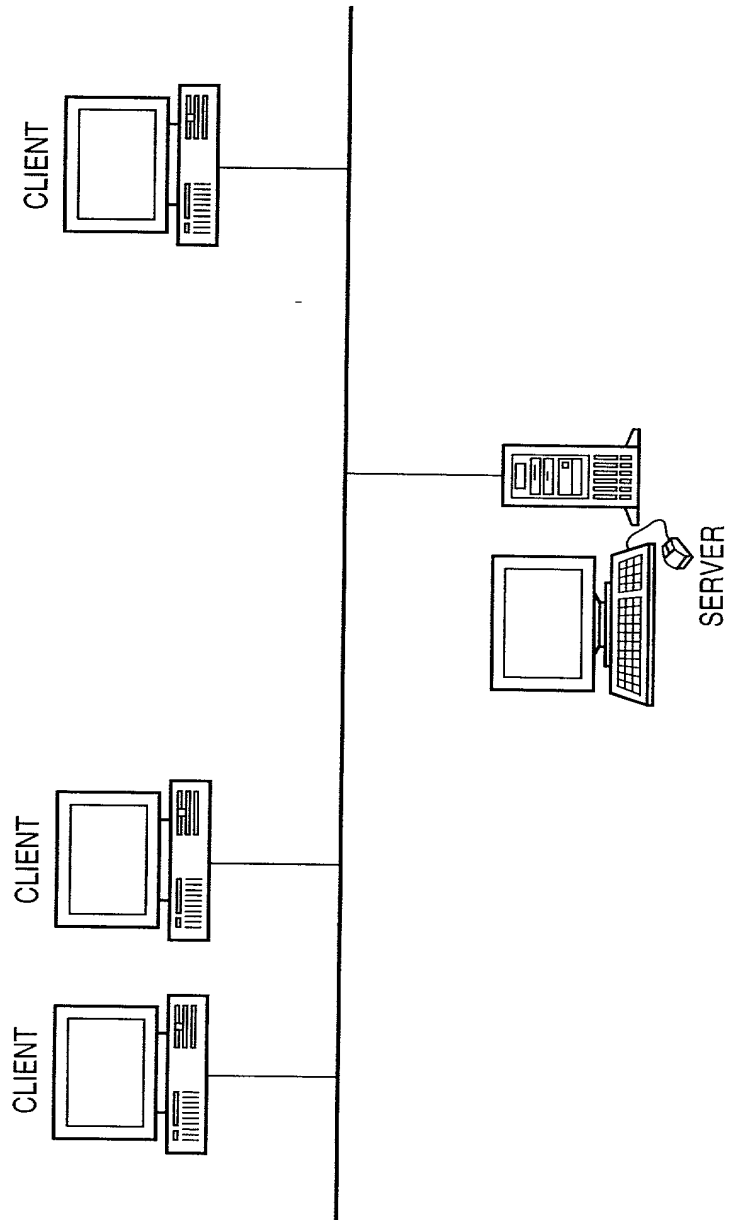
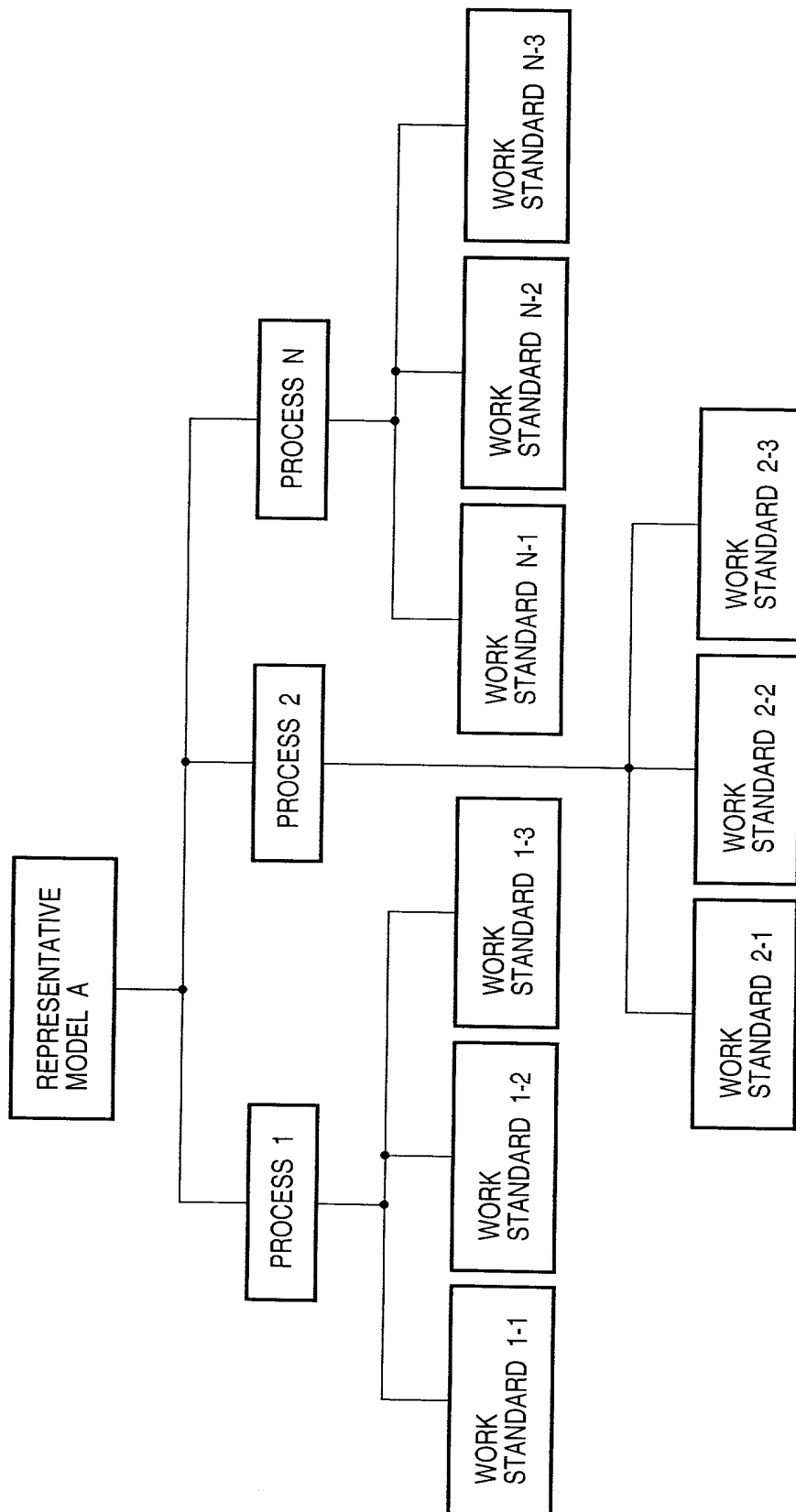


FIG. 1



2/97

FIG. 2



3/97

FIG. 3

WORK STANDARD 01 CREATION					300	
APPLIED						
PART NUMBER		PART NAME	QUANTITY	PART NUMBER	PART NAME	QUANTITY
303		304	305			
TOOL / TREATMENT DEVICE / AUXILIARY MATERIAL						
			QUANTITY	CHECK ETC.		
		306	307	308		
No.	WORK PROCEDURE		No.	NOTE / STANDARD ETC.		
	310					
REVISION NUMBER	CONTENTS OF REVISION	DATE	PERSON IN CHARGE	APPROVE	WORK NAME	
01	CREATED	1997/09/25				
					MANAGEMENT NO.	

301

302

309

313

311

312

FIG. 4

STRUCTURE OF MASTER FILE

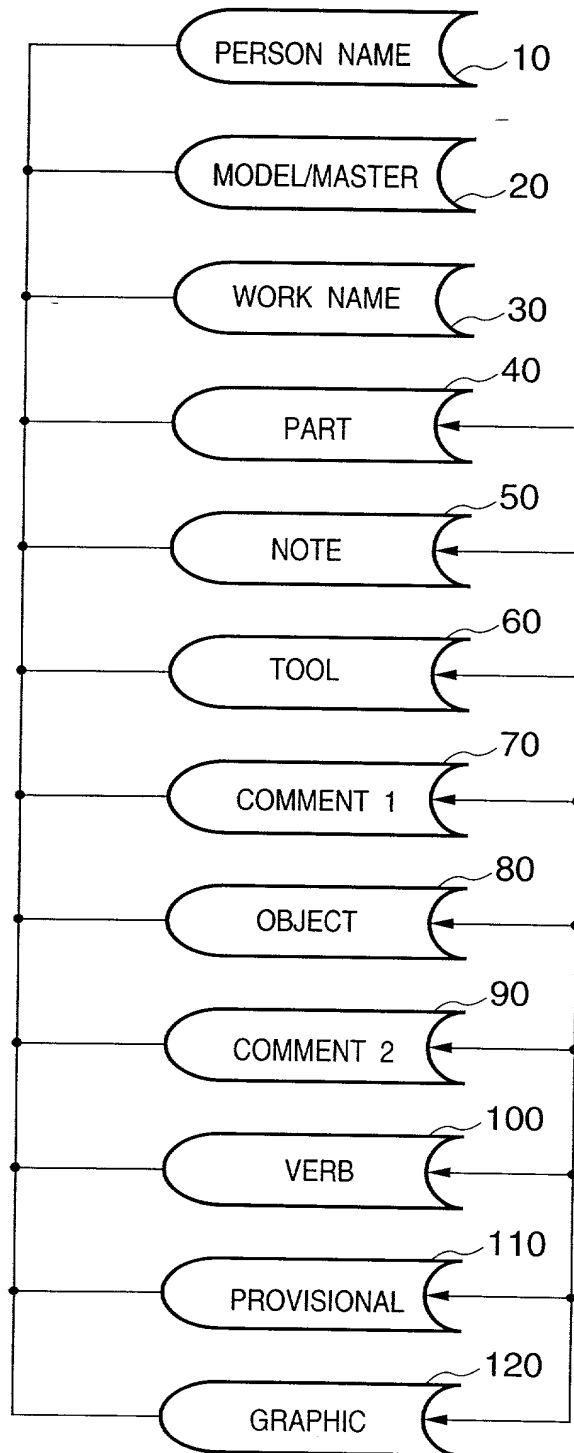


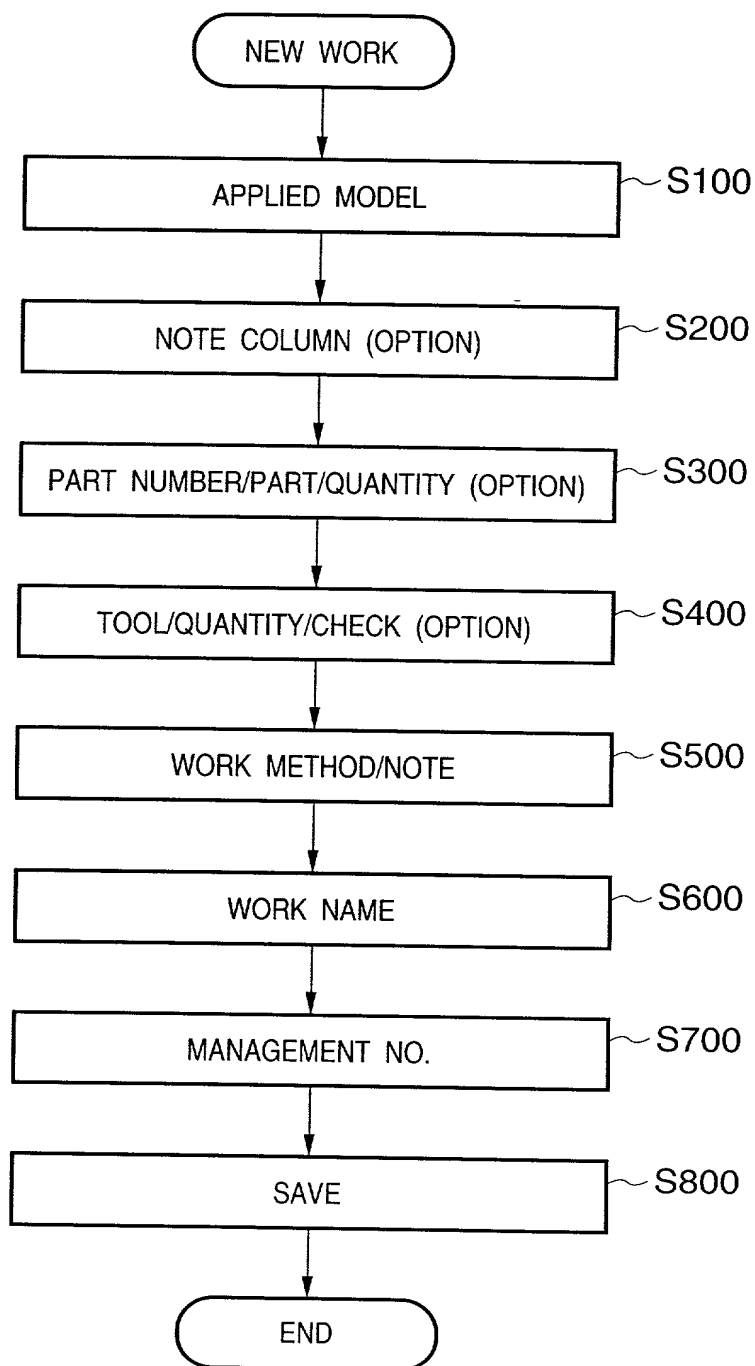
FIG. 5

FIG. 6

SELECTION OF APPLIED MODEL	
LIST OF APPLIED MODELS	
BJC-4200 SYSTEM	
BJC-420J	
BJC-420J (BLACK)	
BJC-4300	
BJC-430J	
BJC-4200LX	
A250 II Q	
BJC-4200	
OK	CANCEL

FIG. 7

WORK STANDARD 01 CREATION				<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	
APPLIED					
BJC-420J BJC-420J(BLACK) BJC-430J					
PART NUMBER	PART NAME	QUANTITY	PART NUMBER	PART NAME	QUANTITY

302

FIG. 8

PART NUMBER	PART NAME	QUANTITY	PART NUMBER
PART			
000 - 0000 - 001	PART 001	▲	
000 - 0000 - 002	PART 002		
000 - 0000 - 003	PART 003		
001 - 0000 - 001	PART 101	▼	
001 - 0000 - 002	PART 102		
111 - 1111 - 001	PART 001		
A01 - 1234 - 001	TEST PART 0001		

FIG. 9

• WORK NAME

• CANDIDATES

- (SET ORIGINAL GLASS PROTECTIVE SHEET)
- (HOOK DEVELOPING RAIL RETURN SPRING)
- (HOOK DEVELOPING RAIL RETURN SPRING(AFTER))
- (SET ORIGINAL GLASS TABLE)
- (SET ORIGINAL TABLE PROTECTIVE SHEET)
- (CHECK NO TONER IN DEVELOPER)
- (CHECK ERROR IN DEVELOPER)
- (LOCK DEVELOPER)

A curved arrow points from the 'WORK NAME' input field to the 'CANDIDATES' list.

FIG. 10

- WORK NAME
- CANDIDATES

(HOOK DEVELOPING RAIL RETURN SPRING)

(HOOK DEVELOPING RAIL RETURN SPRING(AFTER))

(CHECK NO TONER IN DEVELOPER)

(CHECK ERROR IN DEVELOPER)

(LOCK DEVELOPER)

FIG. 11

1100

WORK STANDARD SYSTEM

WORK NAME :

WORK METHOD :

1101 (COMMENT 1)

1102 (OBJECT)

1103 (COMMENT 2)

1104 (VERB)

00 ※ 1105a

01 1105b

1105

NOTE, STANDARD / REQUIRED QUALITY :

1106

1107

OK 1108 CANCEL

FIG. 12

WORK STANDARD SYSTEM	
WORK NAME :	
WORK METHOD :	
	1201
	1202
00 ※	1105b
01	

FIG. 13

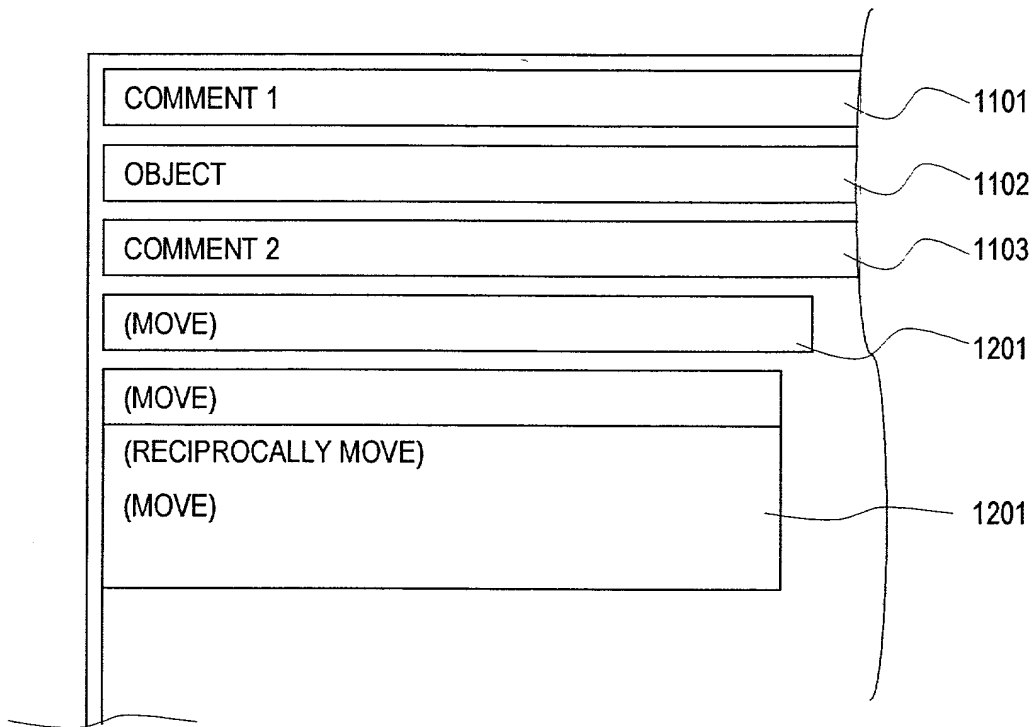


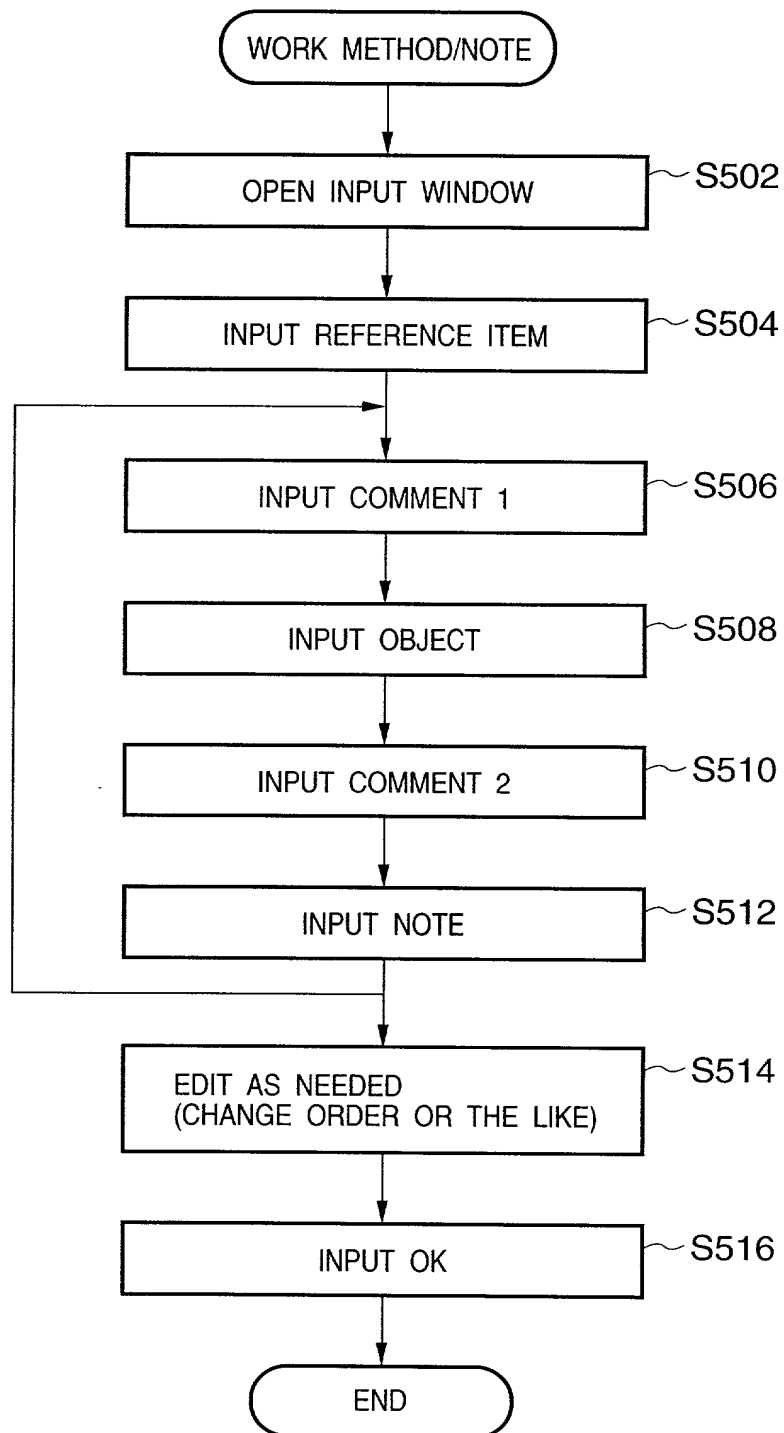
FIG. 14

FIG. 15

00	※	
01	DO zzzz SUCH THAT xxxx AT wwww POSITION BECOMES yyyy	
02	WIND AV CORD	
03	CONFIRM 100V SYSTEM	
04	SET CRG HOLDER	

FIG. 16

NOTE, STANDARD / REQUIRED QUALITY	1601
NOTE	
SEPARATION GRIPPER MOVES SLOWLY WITHOUT GRIPPER SPRING OF ASF _u DON'T PULL TAPE TOO STRONG TO MAKE SIDE GUIDE LOOSE DON'T HOOK PAPER GUIDE u ON SHEET HOLDER BEWARE OF IMITATIONS BEWARE OF IMITATIONS(Color Style Write	1602

FIG. 17

NOTE, STANDARD / REQUIRED QUALITY	
1	NOTE

1107

FIG. 18

CONFIRM	
00 ※	
01 CONFIRM 100V SYSTEM	
02 WIND AV CORD	CUT(I)
03 SET CRG HOLDER	COPY(C)
04	PASTE(P)
	ADD(A)
	DELETE(D)
	UNDO
	REVISE(CHANGE)
	REVISE(DELETE)
NOTE, STANDARD / REQUIRED QUALITY	

1802

FIG. 19

CONFIRM	
00 ※	
01 WIND AV CORD	
02 CONFIRM 100V SYSTEM	
03 SET CRG HOLDER	
04	

NOTE, STANDARD / REQUIRED QUALITY

FIG. 20

CONFIRM	
00 ※	
01 WIND AV CORD	
02 SET CRG HOLDER	
03	<div><div>CUT(I) COPY(C) PASTE(P)</div><div>ADD(A) DELETE(D)</div><div>UNDO REVISE(CHANGE) REVISE(DELETE)</div></div>
NOTE, STANDARD / REQUIRED QUALITY	

1802

FIG. 21

WORK STANDARD SYSTEM	
WORK STANDARD(E)	EDIT(E) ILLUSTRATION(I) SHIPMENT DESTINATION
CREATE(N) Ctrl + N	✂ 📄 📁 ←
OPEN(O) Ctrl + O	
CLOSE(C)	
CLOSE ALL	
SAVE(S) Ctrl + S	
SAVE REVISE(A) Ctrl + A	
SAVE ALL	PART
DELETE(D)	
DELETE FROM LIST	
PREVIEW(V)	
PRINT(P) Ctrl + P	
PRINT FROM LIST	
END(X)	

FIG. 22

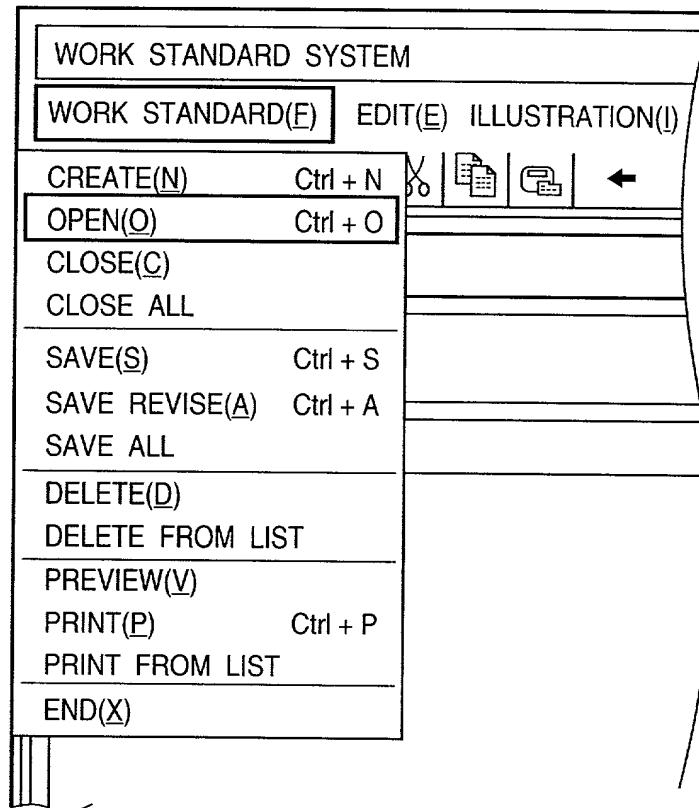


FIG. 23

X

WORK STANDARD SYSTEM

☒ LATEST REVISION NUMBER
 ☐ ALL





MANAGEMENT NO.	REVISION NUMBER	WORK NAME	DATE OF REGISTRATION
SO - 04 - 01(4) - E	01	SET ASFu	1997/09/13
SO - 01 - 01(3) - E	01	SET BASE TRAY	1997/09/01
SO - 01 - 03 - E	01	SET BASE TRAY	1997/09/01
SO - 01 - 04 - E	01	SET BASE TRAY	1997/09/01
SO - 06 - 01 - E	01	WIRING	1997/09/01
SO - 06 - 02 - E	01	WIRING	1997/09/01
SO - 06 - 03 - E	01	WIRING	1997/09/01
SO - 07 - 01(2) - E	01	GREASING	1997/09/01
SO - 08 - 01 - E	01	SET RAIL	1997/09/01

OK

CANCEL

2301

FIG. 24

SYSTEM			
EDIT(E)		ILLUSTRATION(I)	SHIPMENT DESTINATION(S)
		VIEW(V)	 
		EDIT(E)	
01 CREATE		PowerPoint	
		✓ Canvas	

|

FIG. 25

WORK STANDARD 01 CREATION

APPLIED

PART NUMBER

303

PART NAME

TOOL / TREATMENT DEVICE

WORK PROCEDURE

No.

FILE NAME :

2501

UPDATE

2502

CLEAR

2503

CLOSE

2504

REVISION NUMBER	CONTENTS OF REVISION	DATE	PERSON IN CHARGE	APPROVE	WORK NAME
01	CREATED	1997/09/25			
					MANAGEMENT NO.

FIG. 26

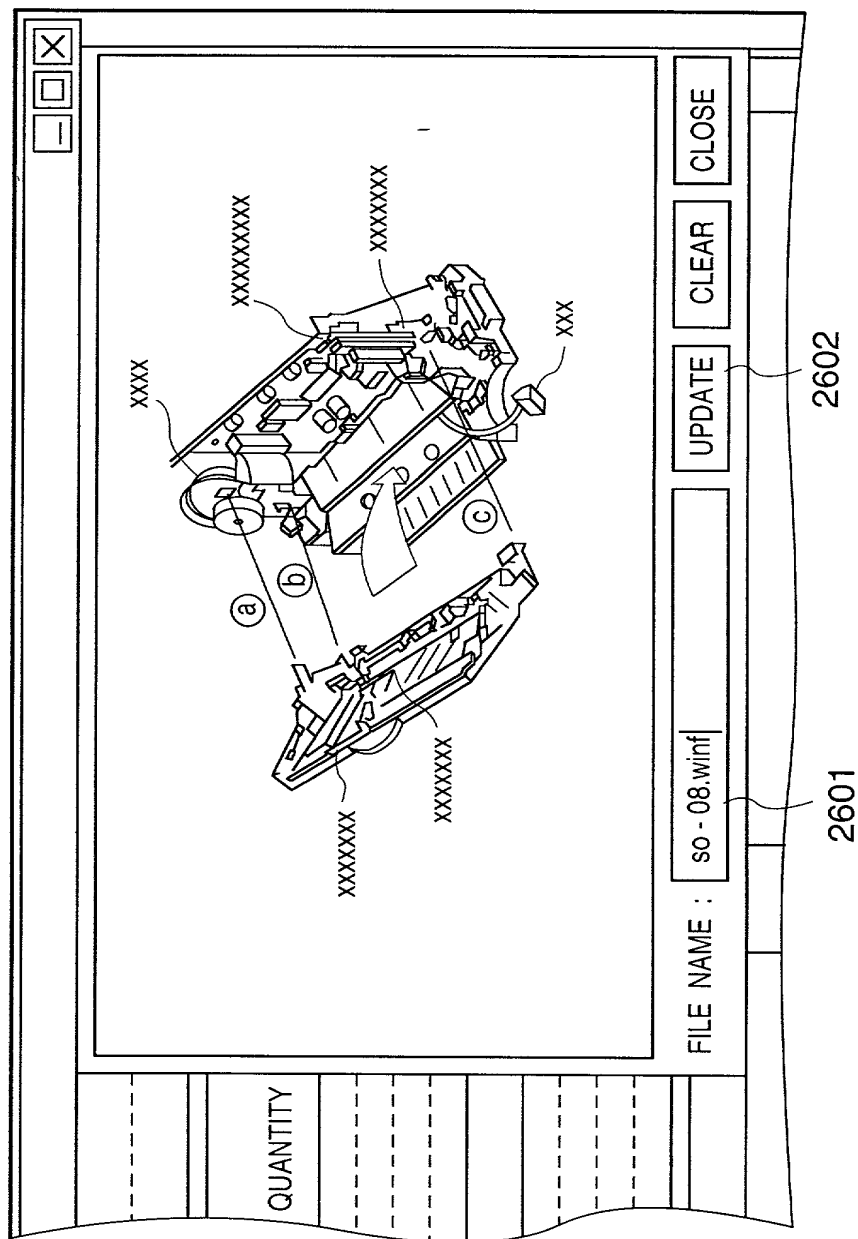


FIG. 27

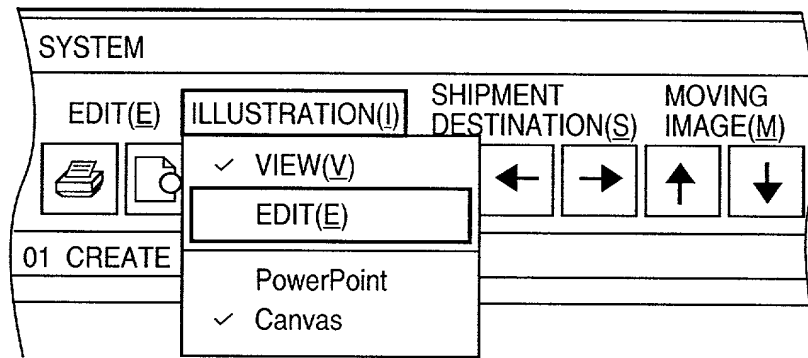


FIG. 28

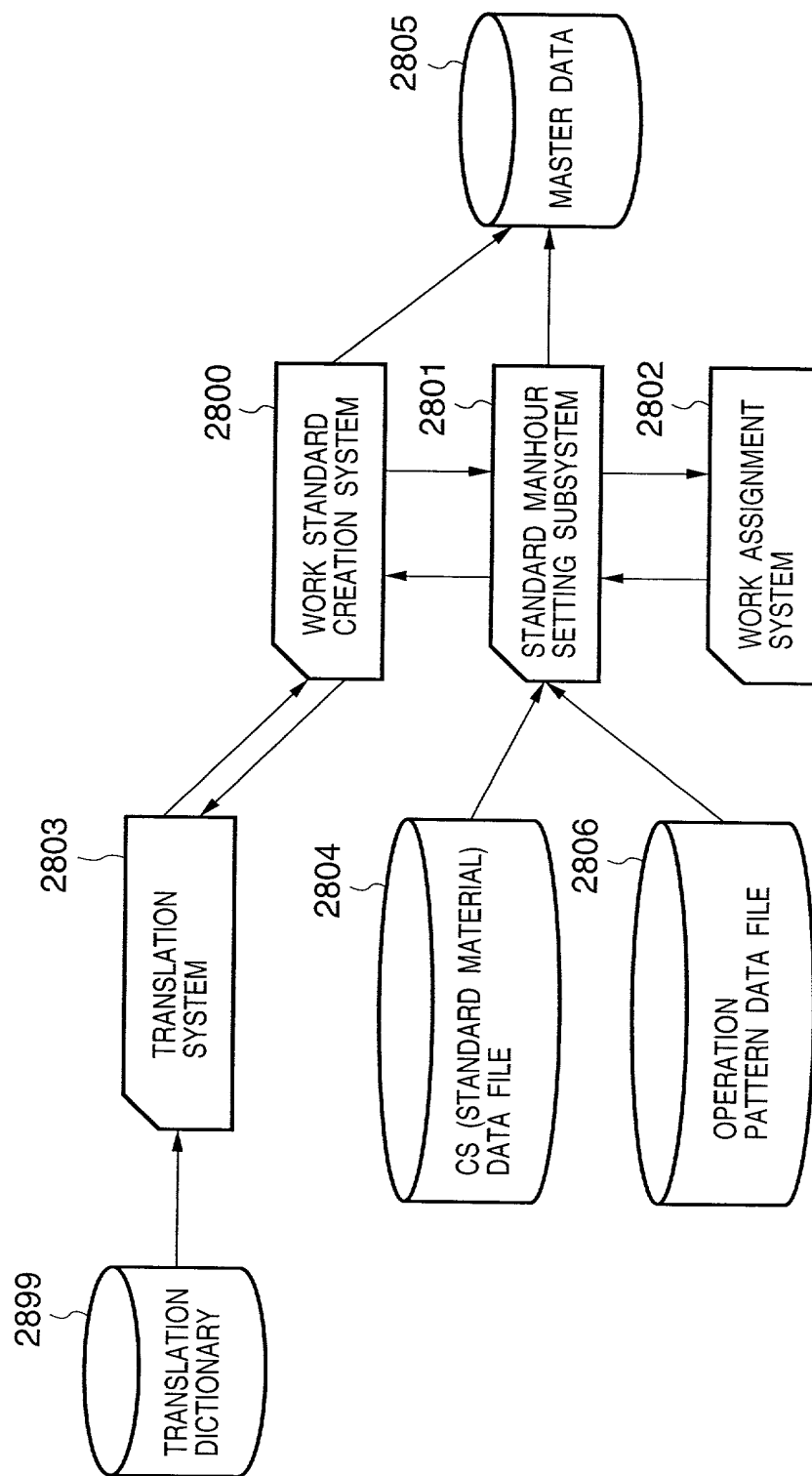


FIG. 29

WORK STANDARD : TRANSLATION SYSTEM (PROTOTYPE) [X]

☒ WORK STANDARD DATA
☐ MASTER DATA

UPLOAD WORK STANDARD

DOWNLOAD WORK STANDARD

TRANSLATE WORK STANDARD

END

FIG. 30

3001 3002 3003 3004 3000

TRANSLATION OF WORK STANDARD

REPRESENTATIVE MODEL NAME : A252

PREPUCES NAME : PLATEN UNIT

☐ TOTAL
☒ ASSEMBLY
☐ UNIT
☐ ASSEMBLY

DISPLAY DATA
☒ ALL
☐ UNTRANSLATED
☐ UNCHECKED

DISPLAY LANGUAGE
☐ JAPANESE
☒ ENGLISH

3006 3007 3008 3005

MANAGEMENT NO.	REVISION NUMBER	WORK NAME	AUTOMATIC TRANSLATION CHECK	
PT - 010 - 010	01	SET CLEANER UP	X	X
PT - 010 - 020	01	SET CLEANER UP	X	X
PT - 010 - 030	01	SET CLEANER UP	X	X
PT - 070 - 030	01	ASSEMBLE CHANGEOVER ARM	X	X
PT - 080 - 010	01	SET TRANSMISSION ROLLER	X	X
PT - 090 - 010	01	SET TRANSMISSION ROLLER	X	X
PT - 100 - 010	01	SET SHEET HOLDER	X	X

3101-

[illegible]

X

WORK PROCEDURE

VOICE(W)

JAPANESE

WORK PROCEDURE

ブレードレバーハネをブレードレバーの ① 部に引っ掛ける

01 ブレードレバーハネをブレードレバーの ① 部に引っ掛ける

02 ブレードレバーを矢印 ② 方向にスライドさせ引っ掛かり無くハネ力で戻ることを確認する

03 ブレードレバー軸先端がブレードホルダー先端まで圧入されていることを確認する

ENGLISH

Procedure

The blade lever spring hooks to ① of the blade lever.

01 The blade lever spring hooks to ① of the blade lever.

02 Side the blade lever in the direction of arrow ② and there is no catch and n...

03 Check press-fitting the blade lever shaft leading edge to the braid folder leading ed....

◀
▶

TRANSLATE

OK

CANCEL

3200

3201

3202

3203

3204

FIG. 33

TRANSLATION OF WORK STANDARD (PROTOTYPE)		<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	
WORK STANDARD(E) ILLUSTRATION(I)		VOICE(S) DOW(W)	
WORK STANDARD PN-030-020 01 New		<input type="checkbox"/> <input type="checkbox"/> <input type="checkbox"/>	
Model QG5-1317		X2056) A252 PLATEN UNIT	
<div> <div>PLAY(P)</div> <div>NEW(N)</div> <div>DRIVE(D)</div> </div>		<div> <div>PLAY(P)</div> <div>NEW(N)</div> <div>DRIVE(D)</div> </div>	

FIG. 34

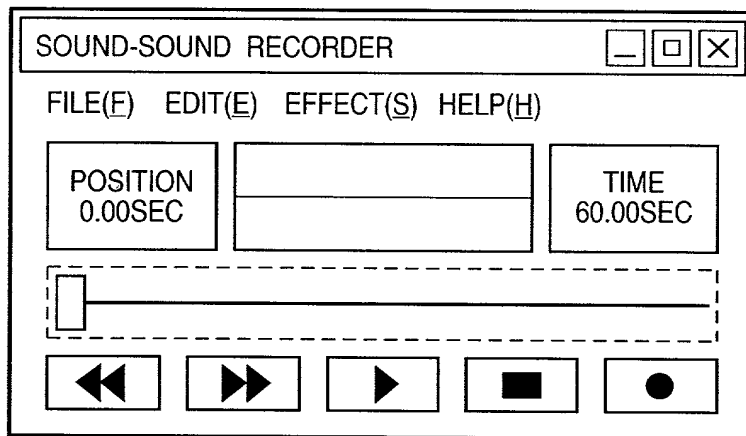


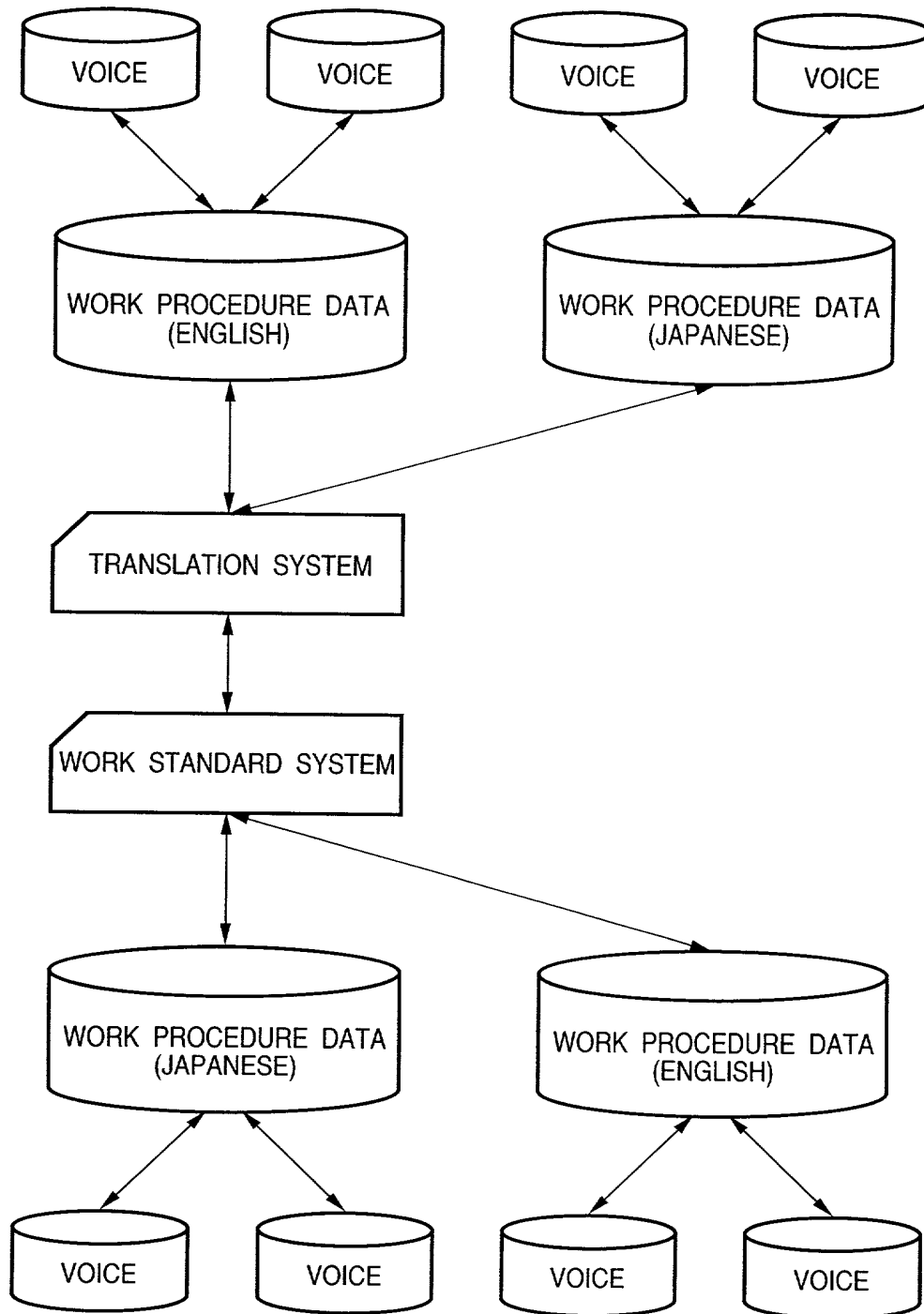
FIG. 35

FIG. 36

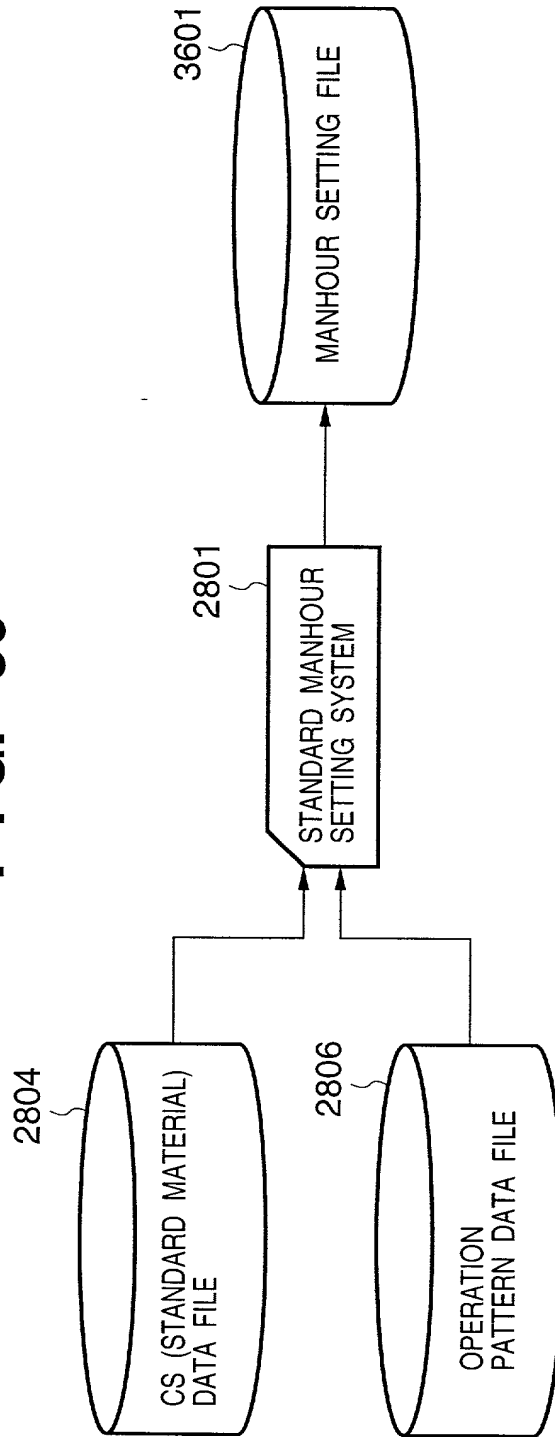


FIG. 37

No.	ELEMENT WORK NAME	FREQUENCY		MANHOUR	CS	SET CONDITION

FIG. 38

FIG. 38

STANDARD MATERIAL DATA

COMMENT 1	OBJECT	COMMENT 2	VERB	SET CONDITION DATA

FIG. 39

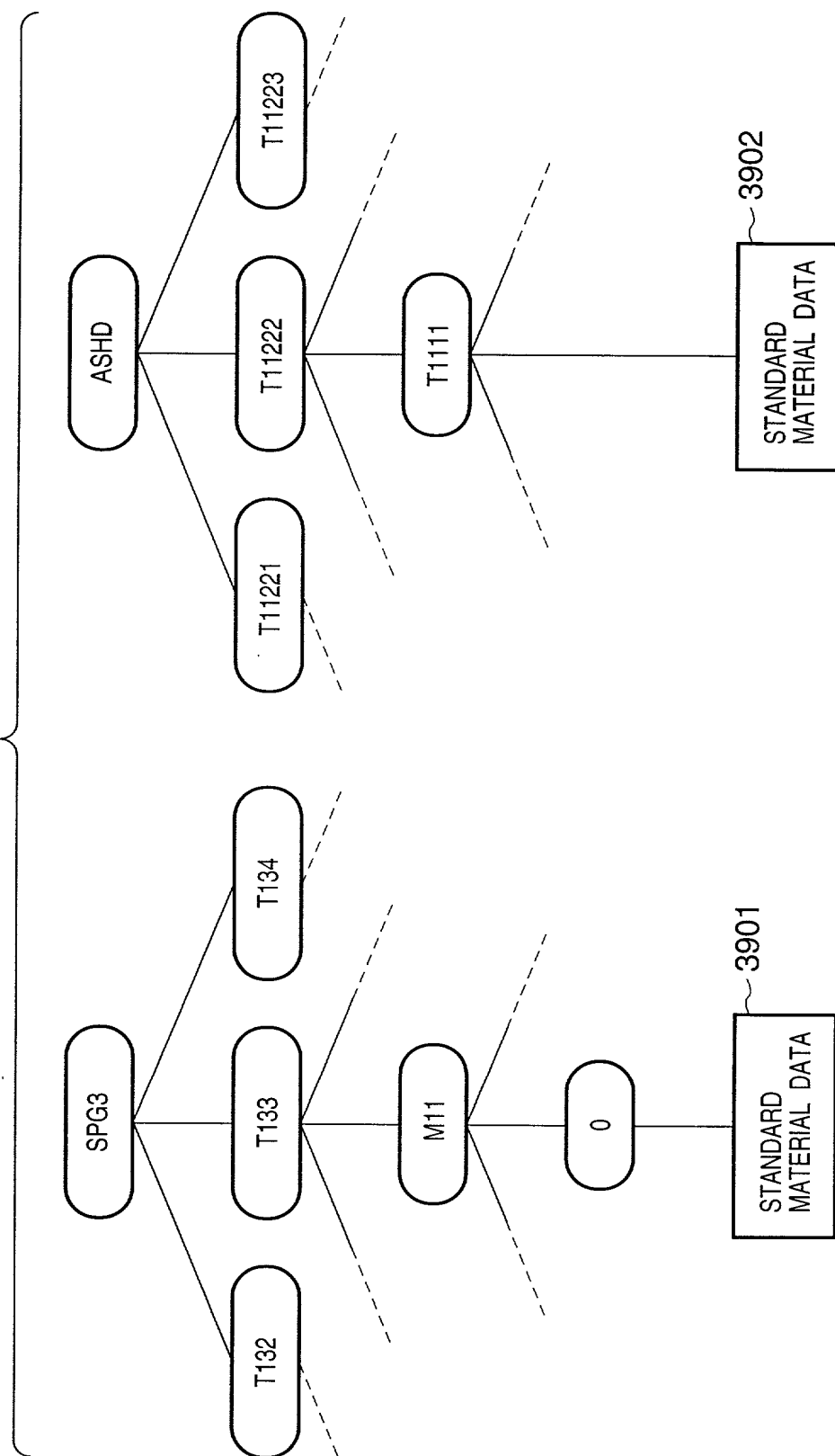
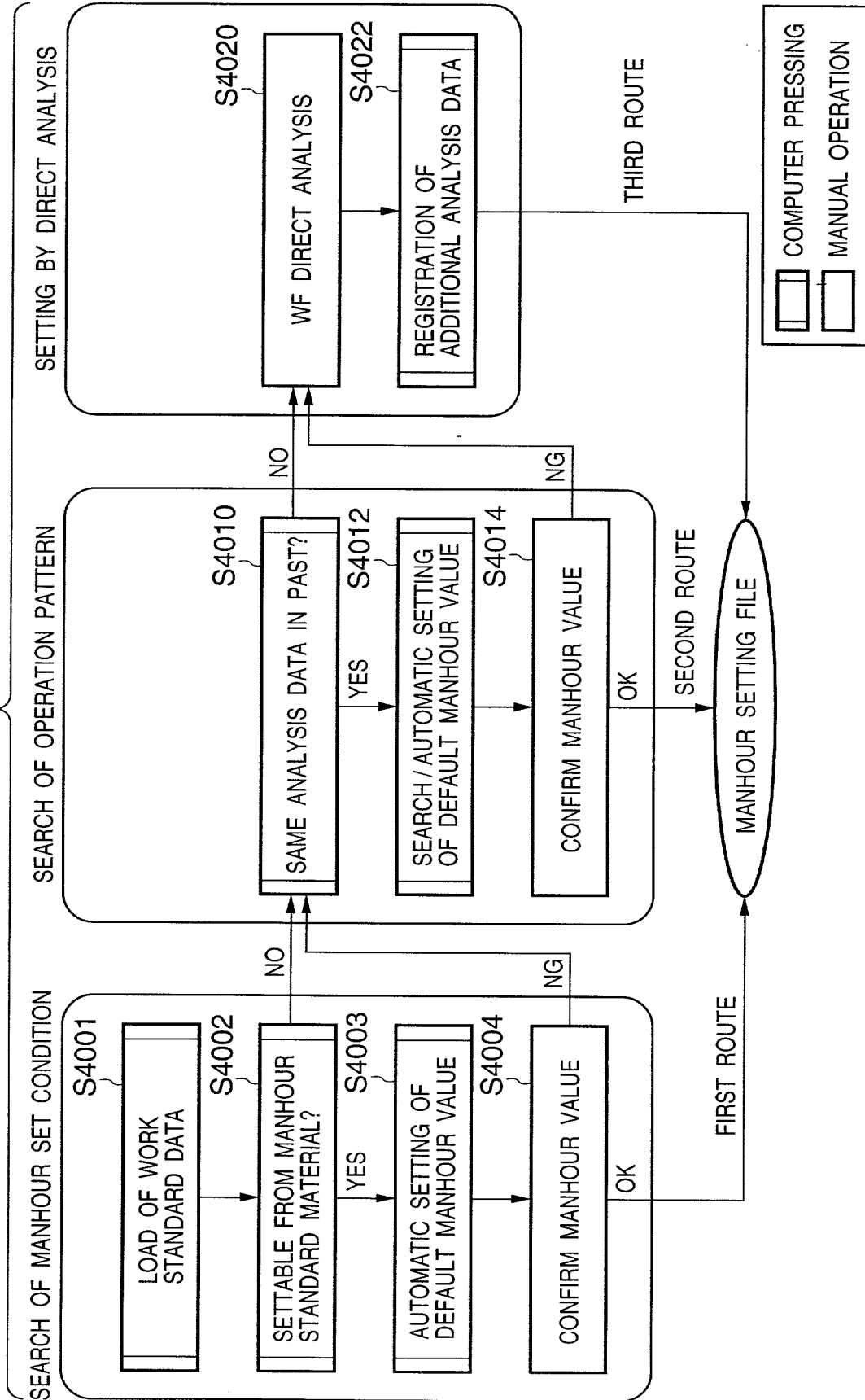


FIG. 40

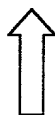


41/97

FIG. 41

3601

EDITING OF ELEMENT WORK						
FILE(F) EDIT(E) VIEW(V) ANALYZE(A) ANALYSIS MATERIAL(B) CS(S) END(X)						
UNIT WORK NAME : SEPARATION ROLLER ATTACHMENT						
No.	ELEMENT WORK NAME	FREQUENCY		MANHOUR	CS	SET CONDITION
1	(SET LOAD SPRING IN TREATMENT DEVICE FOR ATTACHING LOAD SPRING)	1	1			
2	(TURN ON SW OF TREATMENT DEVICE)	1	1			
3	(SET SEPARATION ROLLER SHAFT IN TREATMENT DEVICE FOR ATTACHING LOAD SPRING)	1	1			
4	(TURN OFF SW OF TREATMENT DEVICE)	1	1			
5	(DETACH SEPARATION ROLLER SHAFT FROM TREATMENT DEVICE)	1	1			



DATA LOAD

• ELEMENT WORK NAME

No	COMMENT 1	OBJECT	COMMENT 2	VERB
1		LOAD SPRING	IN TREATMENT DEVICE FOR ATTACHING LOAD SPRING	SET
2	OF TREATMENT DEVICE	SW		TURN ON
3		SEPARATION ROLLER	IN TREATMENT DEVICE FOR ATTACHING LOAD SPRING	SET
4	OF TREATMENT DEVICE	SW		TURN OFF
5		SEPARATION ROLLER	FROM TREATMENT DEVICE	DETACH

[illegible]

SEARCH KEYWORD (KW)

No.	COMMENT 1	OBJECT	COMMENT 2	VERB	MANHOUR STANDARD MATERIAL	TIME VALUE
1	*	SPRING	TO *	SET	SPG3 T133/M11/0	41RU
2	*	*	TO *	SET	ASHED T11222/T1111	37RU
3	*	*	FROM *	DETACH	PUMQ T2111/T111111	16RU
4	*	E-RING	*	SET	RIN2 T11211/SO	76RU
5	*	CONNECTOR	*	INSERT	CONN T11211/SO	41RU
6	*	*	*	SCREW TIGHTLY	SCR6 M211/1	23RU

2804

MATCH

2806

3601

✕ □ ▮

UNIT WORK NAME : SEPARATION ROLLER ATTACHMENT

[illegible]

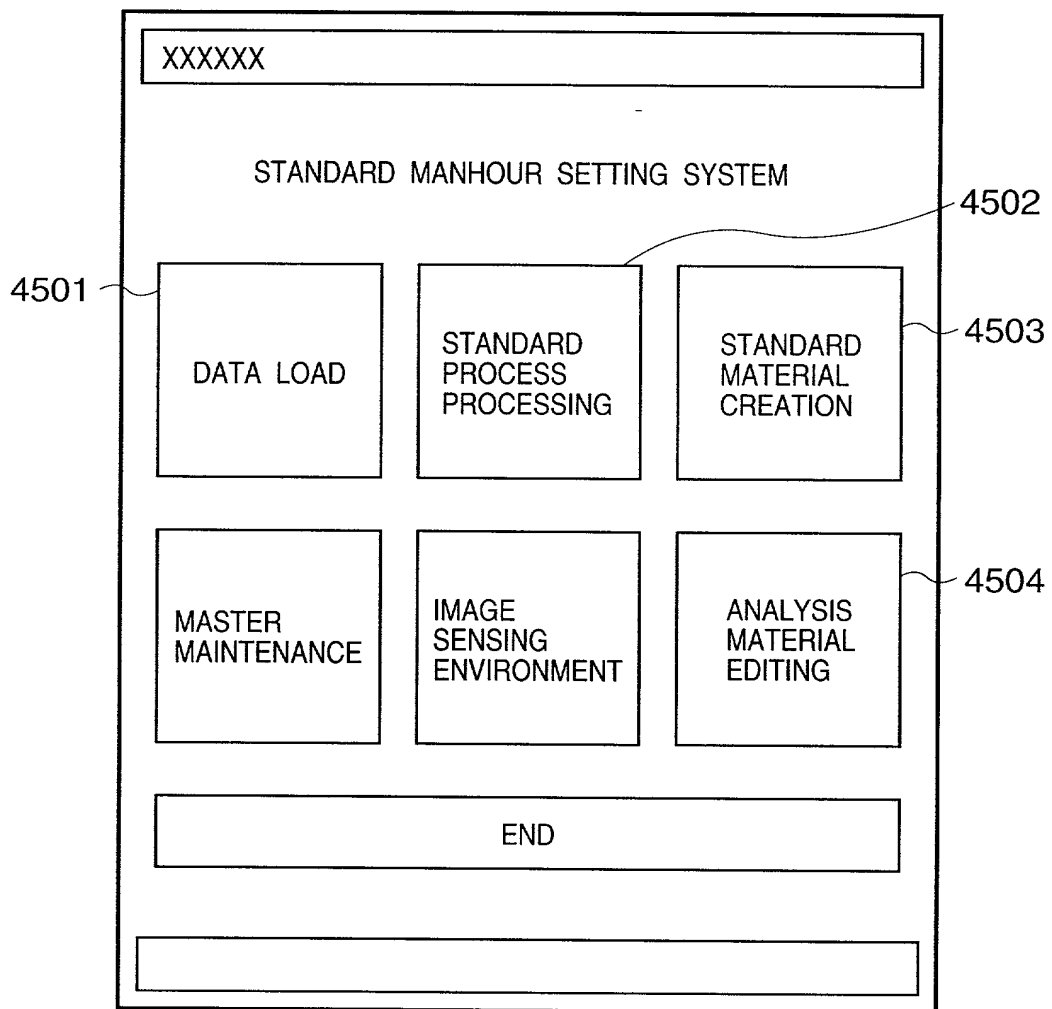
FIG. 45

FIG. 46

4609 4610

XXXXXX

4601

☒ ALL ☐ DESIGNATE : 4612

PRODUCT NUMBER :

NAME :

PRODUCT NUMBER	WORK STANDARD	PRODUCT SYMBOL	NAME	PREVIOUS LOAD DATE
0 - CLOCK	XXXX	XX	XXXX	XXX
XXXXXX		BL - OLD	SET IN 1996	
xyz - test				
test - 01				
tesr - AMI				

4605

4602 4603 4604

[illegible]

FIG. 48

4805 4804

LOAD OF DATA

4800

COMPONENT DESIGNATION

4801

☐ ALL

☒ DESIGNATE COMPONENT

4802

CH

AUTOMATIC MANHOUR SETTING

☒ STANDARD MATERIAL(CS)

☒ ANALYSIS MATERIAL

4803

EXECUTE

CANCEL

4806

FIG. 49

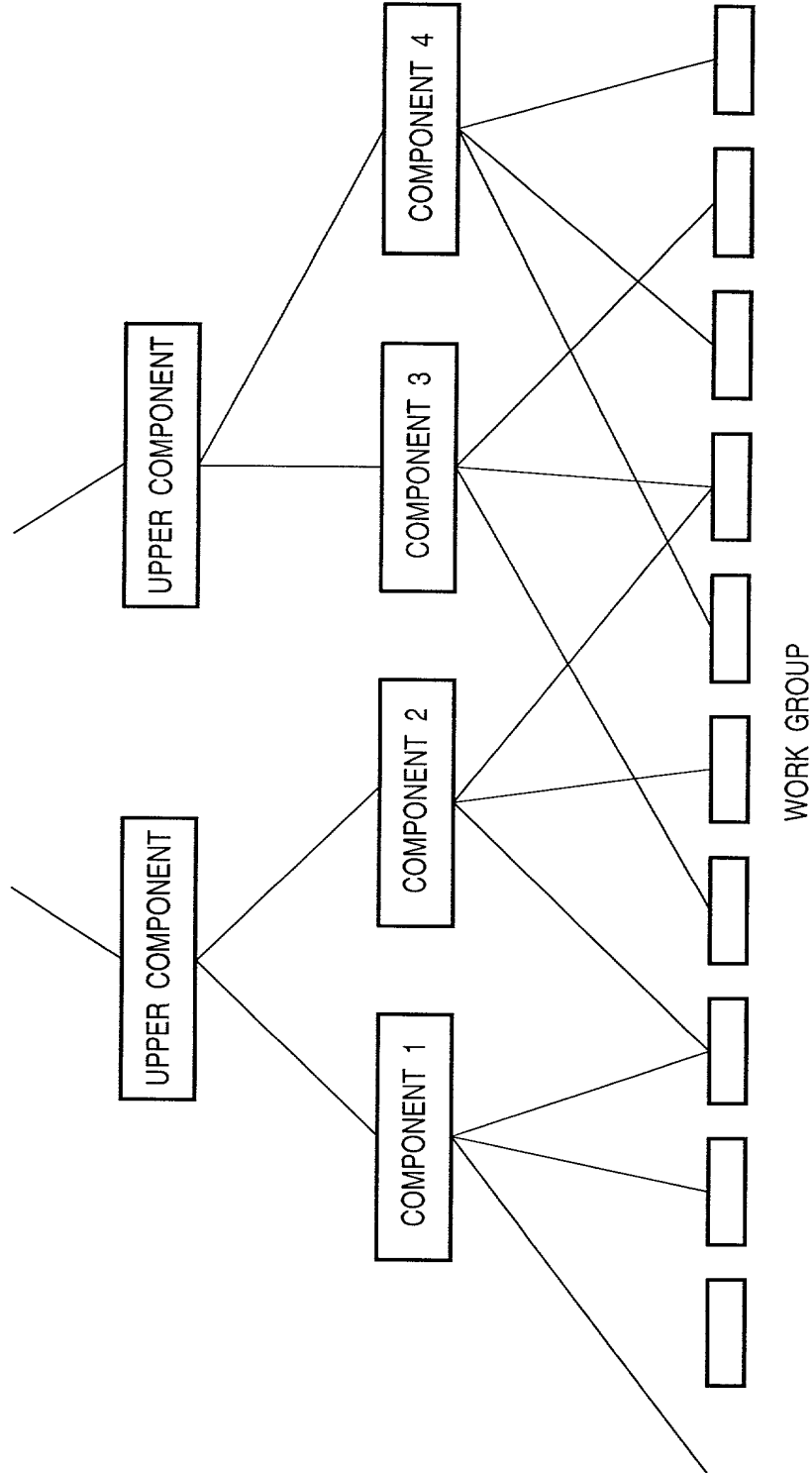


FIG. 50

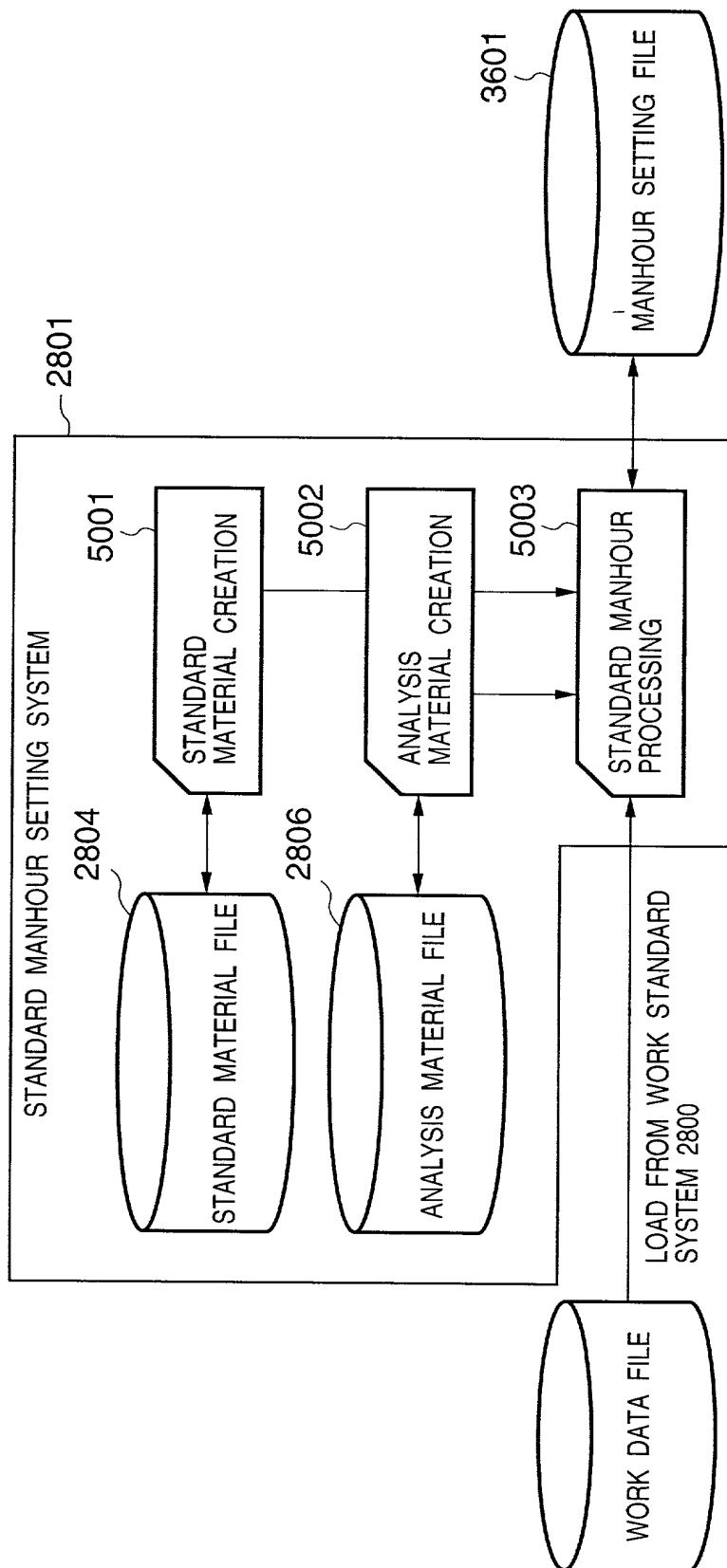


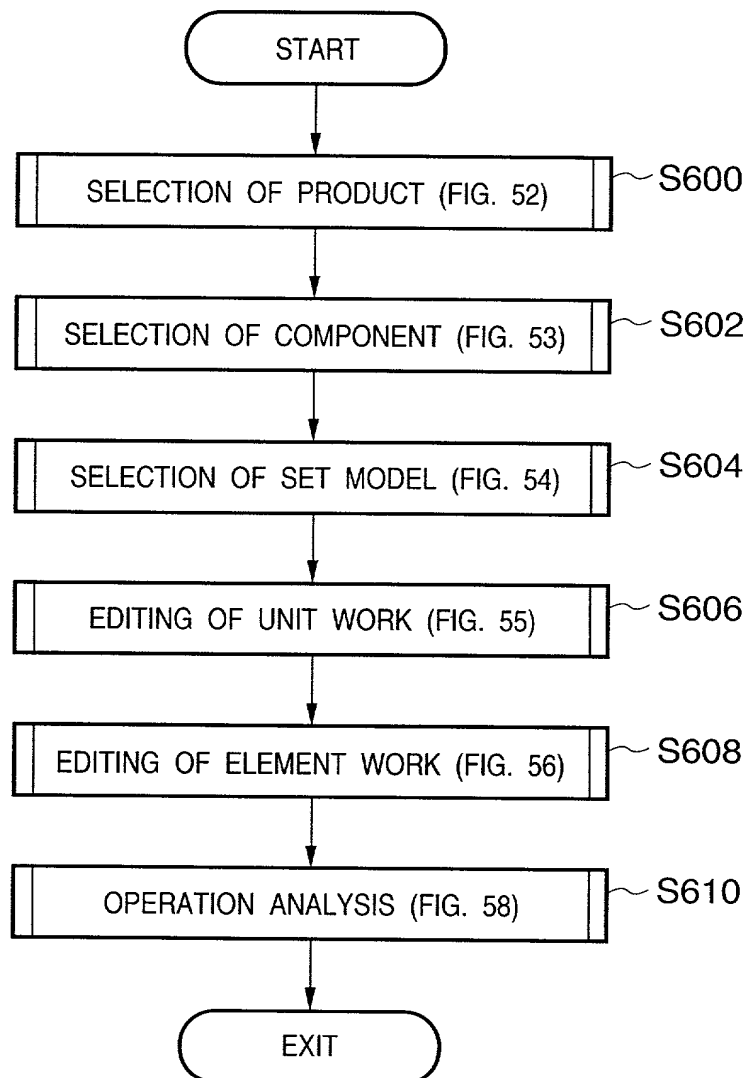
FIG. 51

FIG. 52

SELECTION OF PRODUCT

FILE(F) EDIT(E)

PRODUCT SYMBOL	NAME	PREVIOUS UPDATE DATE
BJ - 970909	XXXXX	1997/09/22 10:17:30
BJ - STAND		1997/09/12 15:09:09
BJ - test	TEST 01 Standard	1997/09/18 10:38:14
BJ250	250 TESTS	1997/09/17 17:58:59
ST01	STAND PRODUCT	1997/09/12 16:02:34
STAND01		1997/09/19 15:46:04

SET MANHOUR
 EXTRACT DATA
 CREATE HOST TRANSFER
 ANALYZE DATA
 END

1. The first part of the paper is devoted to a review of the literature on the topic. It starts with a general overview of the field, followed by a more detailed discussion of the specific issues at hand. The author then presents his own findings, which are based on a series of experiments. Finally, he concludes with some thoughts on the implications of his work.

1. The first part of the paper is devoted to a review of the literature on the topic. It starts with a general overview of the field, followed by a more detailed discussion of the specific issues at hand. The author then presents his own findings, which are based on a series of experiments. Finally, he concludes with some thoughts on the implications of his work.

FIG. 54

SELECTION OF MODEL

FILE(E) EDIT(E) VIEW(V)

PRODUCT NUMBER : BJ - 970909

NAME : 97 - 09 - 09 LOAD

COMPONENT SYMBOL : CH

NAME :

SET MODEL SYMBOL	QUANTITY	NAME	PREVIOUS PUBLICATION DATE
▲ A250 IIQ			
BJC - 4200LX			
BJC - 4200 SYSTEM			
BJC - 420J			
BJC - 420J(BLACK)			
BJC - 4300		XXXXX	1997/09/09 10:46:33
BJC - 430J			

NEXT

REGISTER PUBLICATION

LOOK PUBLICATION

DISPLAY SAME MODEL

END

FIG. 55

SELECTION OF MODEL

FILE(E) EDIT(E) VIEW(V)

PRODUCT SYMBOL : BJ - 970909 NAME : 097 - 09 - 09 LOAD SET MODEL SYMBOL : BJC - 4300

COMPONENT SYMBOL : ON NAME : NAME : xxxxxx

LATEST REVISION NUMBER

UPDATE DISPLAY

S	FORMAL MANAGEMENT NO.	REVISION	UNIT WORK NAME	MANHOUR	USE	CS	FREQUENCY
N ⁱ 3	CH-01-01	1	ELECTRIC CHECKING	0	0	0	1
N ⁱ 4	CH-01-02(1)	1	ELECTRIC CHECKING	0	0	0	1
N ⁱ 5	CH-01-02(2)	1	ELECTRIC CHECKING	0	0	0	1
N ⁱ 6	CH-01-03	1	ELECTRIC CHECKING	0	0	0	1
N ⁱ 7	CH-01-04	1	ELECTRIC CHECKING	0	0	0	1

N ⁱ 23	CH-07-02(1)	1	SET FRONT COVER	0	0	0	1
N ⁱ 24	CH-07-02(2)	1	SET FRONT COVER	0	0	0	1
N ⁱ 25	CH-07-01(3)	1	SET FRONT COVER	0	0	0	1
N ⁱ 26	CH-07-01(4)	1	SET FRONT COVER	0	0	0	1

No. FORMAL MANAGEMENT NO.

		UNIT WORK NAME		MANHOUR		USE		FREQUENCY		1	2	3	4	5
3	CH-01-01	ELECTRICAL CHECK		0	0	0	0	0	1					

☒ CHANGE ☐ INSERT ☐ ADD

OK

5501
5507
5506
5502
5503
5504
5505

FIG. 56

XXXXXX

📄

🔍

✂

✕

📁

📧

FORMAL MANAGEMENT NO. PUJ-03-01

UNIT WORK NAME : MOTOR ATTACHMENT

TOTAL MANHOUR : 0

NEXT UNIT WORK

NO.	ELEMENT WORK NAME	REVISION	MANHOUR	US	CS	SET CONDITION
1	SET DOUBLE GEAR TO OPPOSITE SIDE OF AXIS IN ORDER OF SMALL GEAR DIAMETER	1	0	0	0	
*						

COMMENT 1 :

TO OPPOSITE SIDE OF AXIS

OBJECT :

DOUBLE GEAR

COMMENT 2 :

IN ORDER OF SMALL GEAR DIAMETER

VERB :

SET

5604

5605

5603

5602

5601

FIG. 57

EDITING OF ANALYSIS MATERIAL

FILE(E) EDIT(E) VIEW(V)

PRODUCT GENRE :

ALL

TYPE	COMMENT 1	OBJECT	COMMENT 2	VERB	ANALYSIS SYMBOL	MANHOUR	USE	FREQ.	COUNT	SET DATE
▶	AIR CAP:	MAIN BODY	AS ARROW 1	INSERT	-50/G1/N/>6/-3	15	0	1	1	97/09/09 9:52
	AIR CAP:	MAIN BODY	AS ARROW 1	INSERT	-50/E/02/N/-6	11	0	1	1	97/09/09 9:53
	AIR CAP:	MAIN BODY	AS ARROW 1	INSERT	-50/G1/N/>6/-3	15	0	1	1	97/09/09 9:55
		ELEMENT WORK 01		VERB	-50/G1/N/>6/-3	15	0	1	1	97/09/09 16:34
	AIR CAP:	MAIN BODY	AS ARROW 1	INSERT	-50/G1/N/>6/-3	15	0	1	1	97/09/09 19:09
		CARRIAGE LOCK		APPLY	Time100/Rate100	100	100	1	1	97/09/09 19:16
	ASSEMBLE MOTOR	PRINTER CHASSIS		INSERT & SET	M211/1/10	50	1	1	1	97/09/09 17:00
		PRINTER CHASSIS		TURN INSIDE OUT	T1221/M2311/0/0	12	0	1	1	97/09/09 17:34
	1			1	T2221/M1211/0/1	24	0	1	1	97/09/09 17:20
	2			2	T1221/M2311/0/0	12	0	1	1	97/09/09 17:24
		PRINTER CHASSIS	ASSEMBLE PR GUIDE	SET		15	0	1	1	97/09/09 11:24
		dgdfafdfas		fdasfdasfasfd	*	16	0	1	1	97/09/09 12:10
		dsdsffsfdsdsaf		fdasfdsdffds	T21121/M1111/0/1	13	0	1	1	97/09/09 12:10
		dgdfafdfas		fdasfdasfasfd	*	16	0	1	1	97/09/09 13:39
		PRINTER CHASSIS	ASSEMBLE PR GUIDE	SET		15	0	1	1	97/09/09 14:00
		PRINTER CHASSIS	ASSEMBLE PR GUIDE	SET		15	0	1	1	97/09/09 14:00
		PRINTER UNIT		SET	Time100/Rate100	100	100	1	1	97/09/09 14:04

FIG. 58

5801		5802		5803		5804		5805	
OPERATION ANALYSIS									
1 SET MAIN BODY TO PREDETERMINED POSITION		TOTAL SIMO VALUE : 0		TOTAL MANHOURLY VALUE : 15		SIMO		NEXT ELEMENT WORK	
NO.	CONTENTS OF OPERATION	WF/OS	SET CONDITION	MANHOURLY	USE	REMARKS			
▲ 1	XXXXXX	PU	-60/Gr1/N/>6/-3	15	0				
*									

FIG. 59

5901

☐ 1. PU

☐ 2. GET

☐ 3. M

☐ 4. MA

☐ 5. ASY

☐ 6. DSY

☐ 7. R

☐ 8. UMAC

☐ 9. MP

☐ 10. BODY

☐ 11. PU

☐ 12. GET

☐ 13. M

☐ 14. MA

☐ 15. ASY

☐ 16. DSY

☐ 17. R

☐ SIMO

SELECT

CANCEL

5902

FIG. 60

XXXXXX

PU

PICK UP

MANUAL

1 :	MOVING DISTANCE	1	-10cm	2	+10cm	3	>50cm	4	5	6
2 :	GRIP TYPE		Qr-3		Qr-2					
3 :	PRE-POSITIONING		NO		YES					
4 :	MAIN SIZE		-10mm		-6mm					
5 :	WEIGHT		<3Kg		>3Kg					

6 :

SET

CANCEL

SET VALUE

FORMULA

6001

6002

6003

FIG. 61

FORMULA

TURN CHANGE DIRECTION OF BODY MANUAL

FORMULA : 10 * m

VARIABLE	VARIABLE NAME	VALUE	UNIT
m :	THE NUMBER OF TIMES OF OPERATION OF CHANGING DIRECTION		COUNT
n :			
p :			
q :			
r :			
s :			

SET

CANCEL

SET VALUE

6101

6104

6103

6102

6105

FIG. 62

The figure shows a graphical user interface window titled "INQUIRY OF LOG". The window contains several input fields and two buttons at the bottom. The fields are labeled as follows:

- 6201**: Points to the title bar of the window.
- 6202**: Points to the "VARIATION AMOUNT" input field, which contains the value "10".
- 6203**: Points to the "USE" input field, which contains the value "0".
- 6204**: Points to the "CHANGE REASON" dropdown menu, which currently shows "SET".
- 6205**: Points to the "OK" button.
- 6206**: Points to the "Clear" button.

The "REASON CODE" field contains the value "1".

FIG. 63

6301 6302

CORRECTION OF CHANGE LOG

DATE

1997 09 22 ○ = ○ FROM

○ BEFORE ○ ~

SEARCH

NO.	UNIT WORK NAME	CODE	CHANGE REASON	NEW MAN/HR	(NEW) MANUAL	(NEW) USE	PREVIOUS (PREVIOUS) MAN/HR	(PREVIOUS) USE	CHANGE DATE
▶ CH-01-01	ELECTRICAL CHECK	1	SET	10	10	0	0	0	1997/09/22 14:30.00

REASON CODE 1 CHANGE REASON

SET

OK

CtR

END

FIG. 64

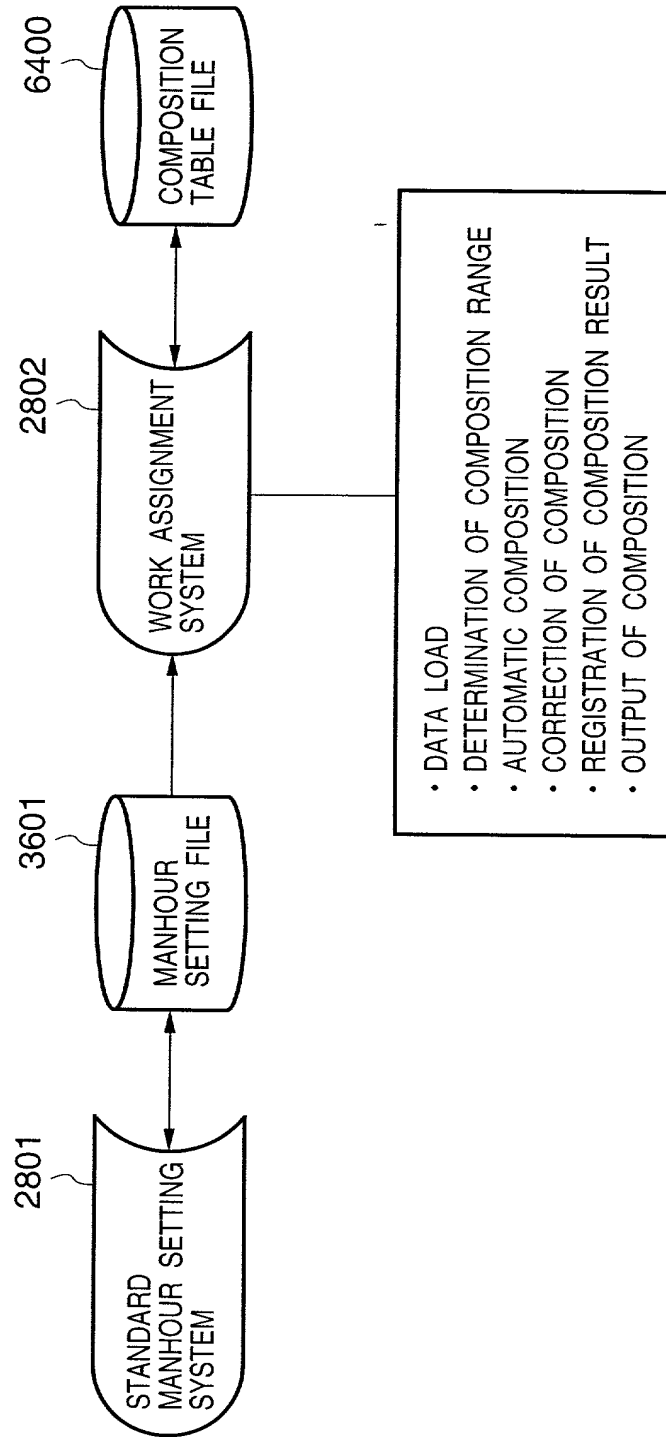


FIG. 65

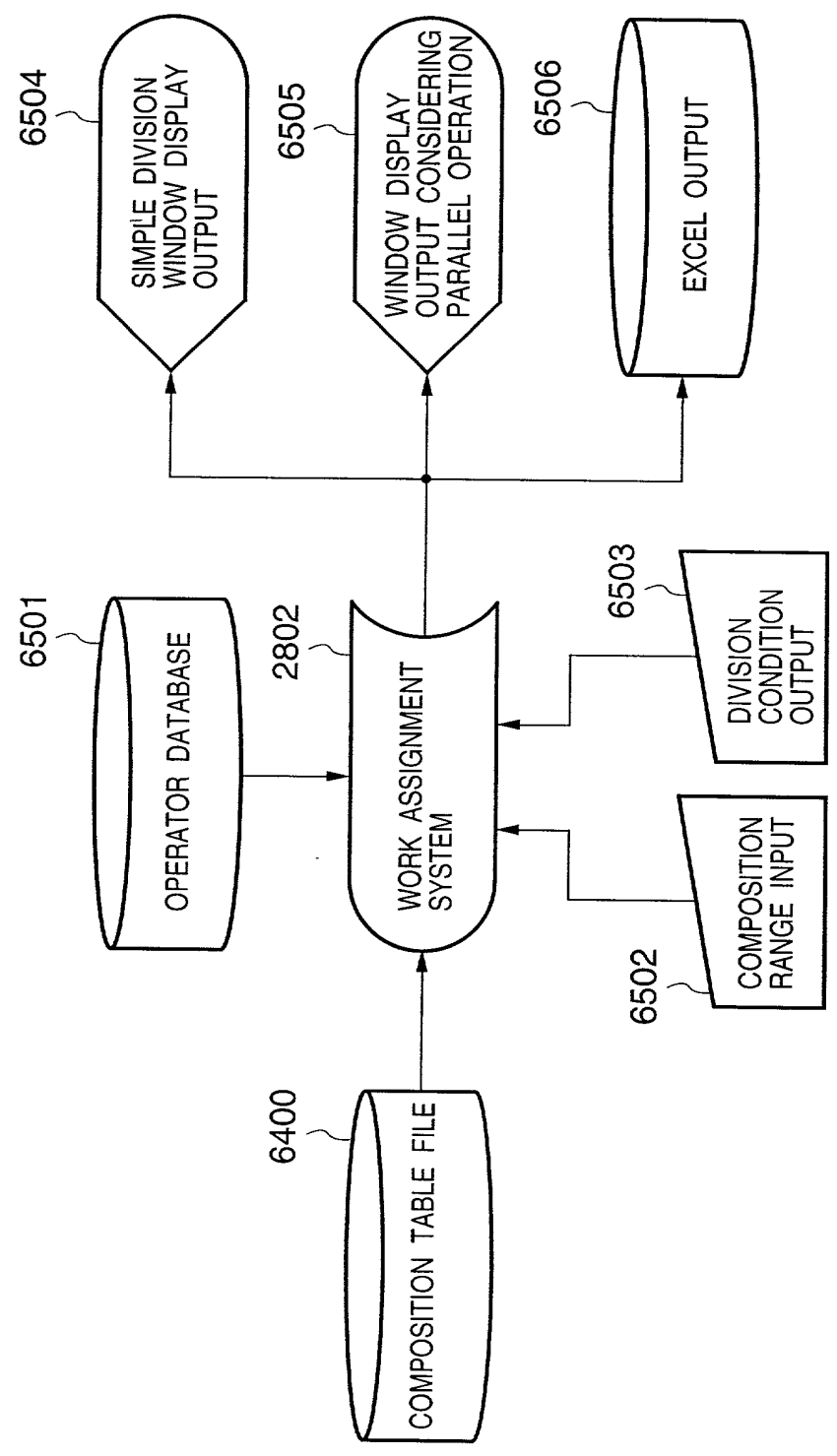


FIG. 66

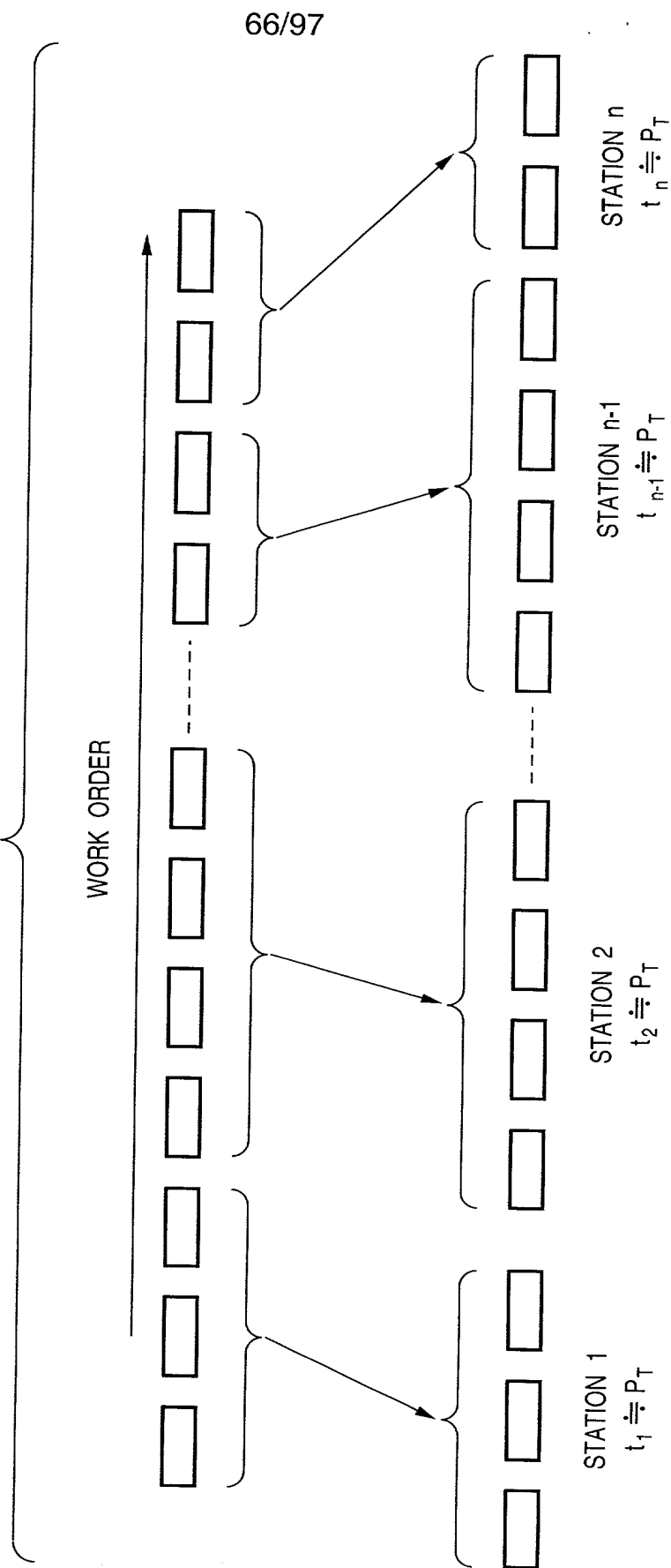


FIG. 67

FILE(F) EDIT(E) INPUT(I) TOOL(O)

MODEL GP55

UNIT

STANDARD NO.	WORK NAME	MANHOUR
0001	STICK HANDY CUT TAPE	134
0002	SET LABELS ON MAIN BODY	550
0003	WEIMAN REMOVAL	270
0004	ASSEMBLE OUTER CASE	365
0005	FIT TOP PAD	268
0006	STICK LARGE-SIDE ORDER LABEL	117

SIMPLE DIVISION

PARALLEL DIVISION

FIG. 68

SIMPLE DIVISION

		▼	▲
FILE(F) EDIT(E)		◆	
St 1			
0001	STICK HANDY CUT TAPE	134	
0002	SET LABELS ON MAIN BODY	550	
0003	WEIMAN REMOVAL	270	
St 2			
0004	ASSEMBLE OUTER CASE	365	
0005	FIT TOP PAD	268	
0006	STICK LARGE-SIDE ORDER LABEL	117	
⋮			

FIG. 69

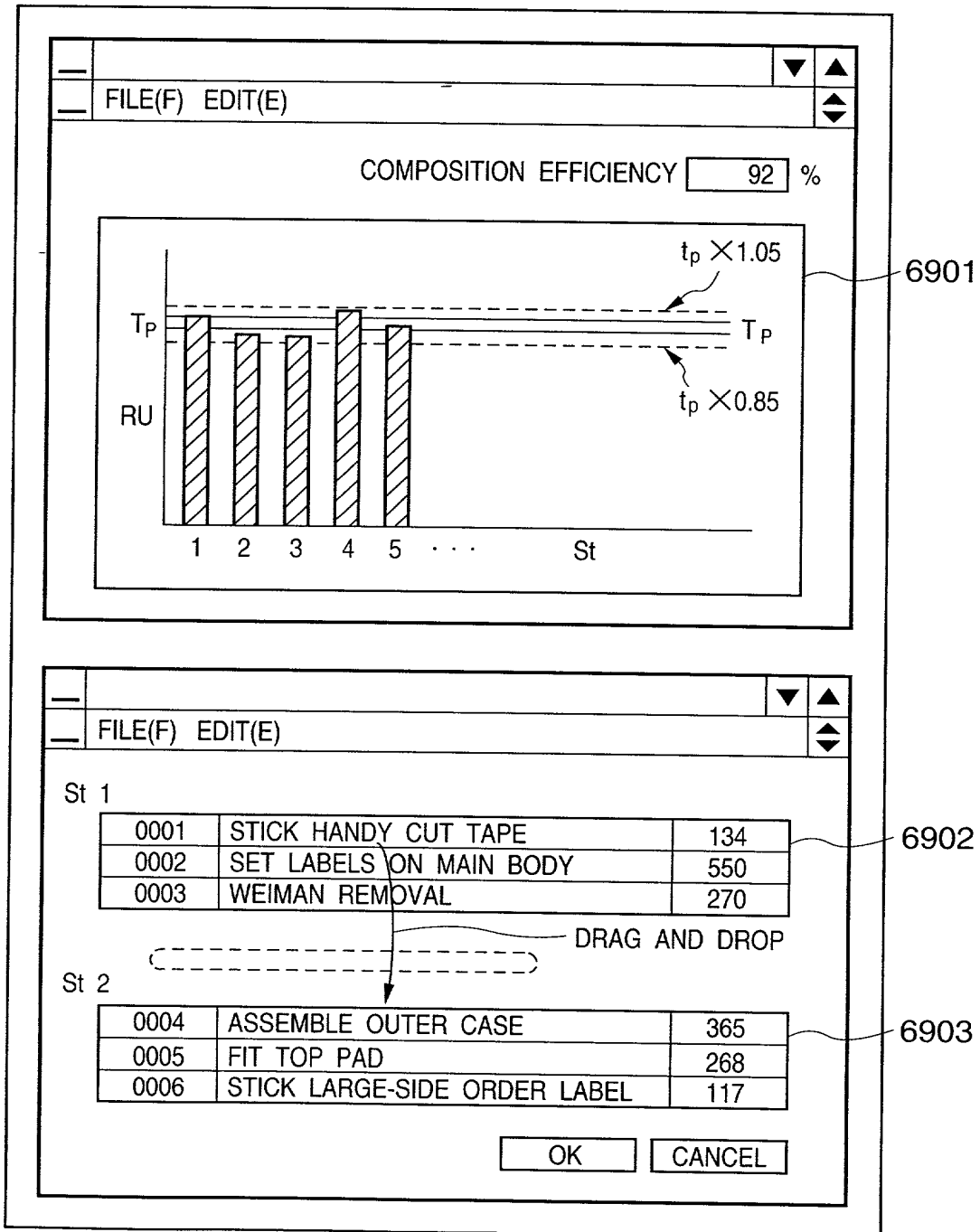


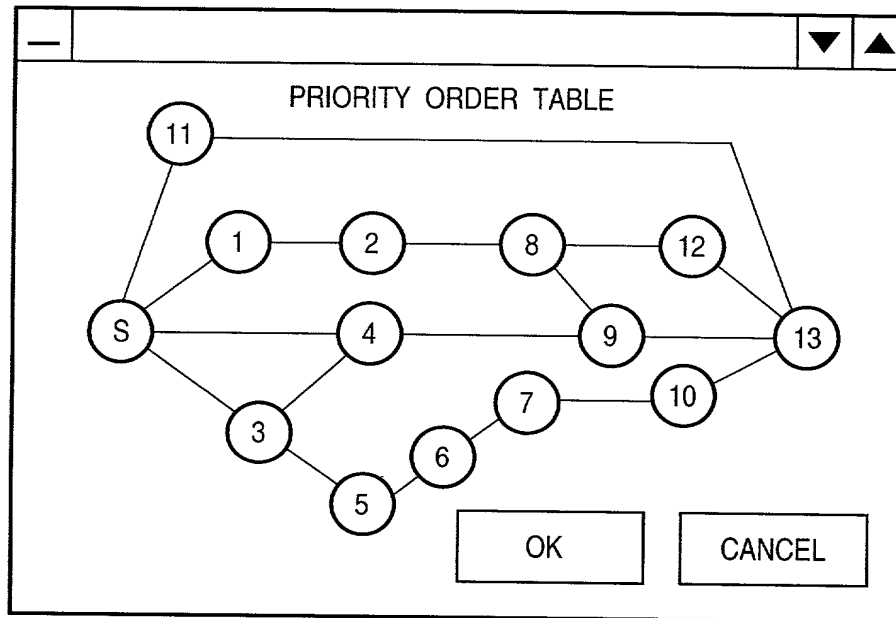
FIG. 70

FIG. 71

PARALLEL DIVISION

				▼	▲
PLAN 2		PLAN 1			
St 1		St 1			
1		1	STICK HANDY CUT TAPE	99	
2		2	SET LABELS ON MAIN BODY	78	
8		3	WEIMAN REMOVAL	134	
St 2		St 2			
3		4	ASSEMBLE OUTER CASE	732	
4		5	FIT TOP PAD	268	
5		6	STICK LARGE-SIDE ORDER LABEL	117	
			⋮		

FIG. 72

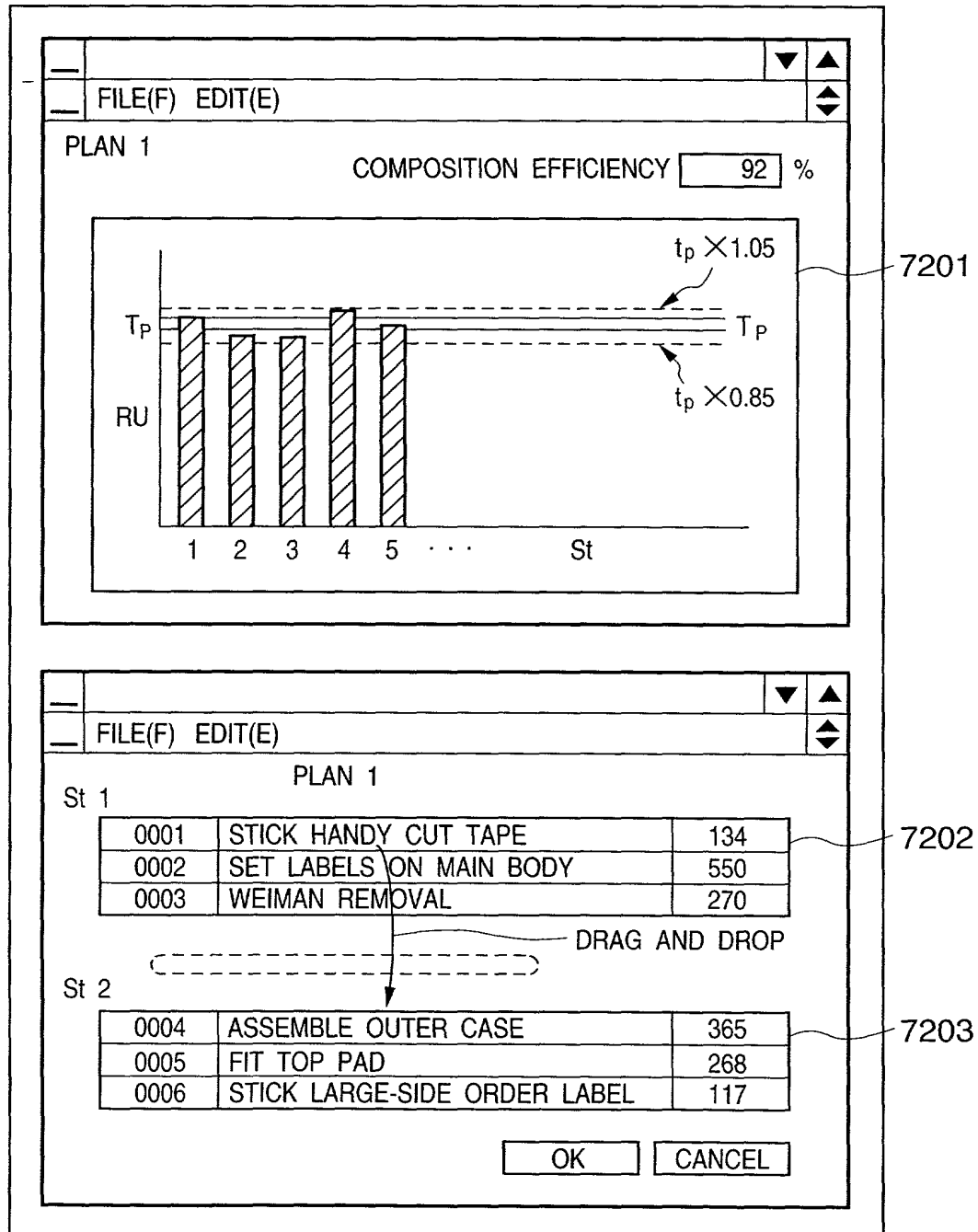


FIG. 73

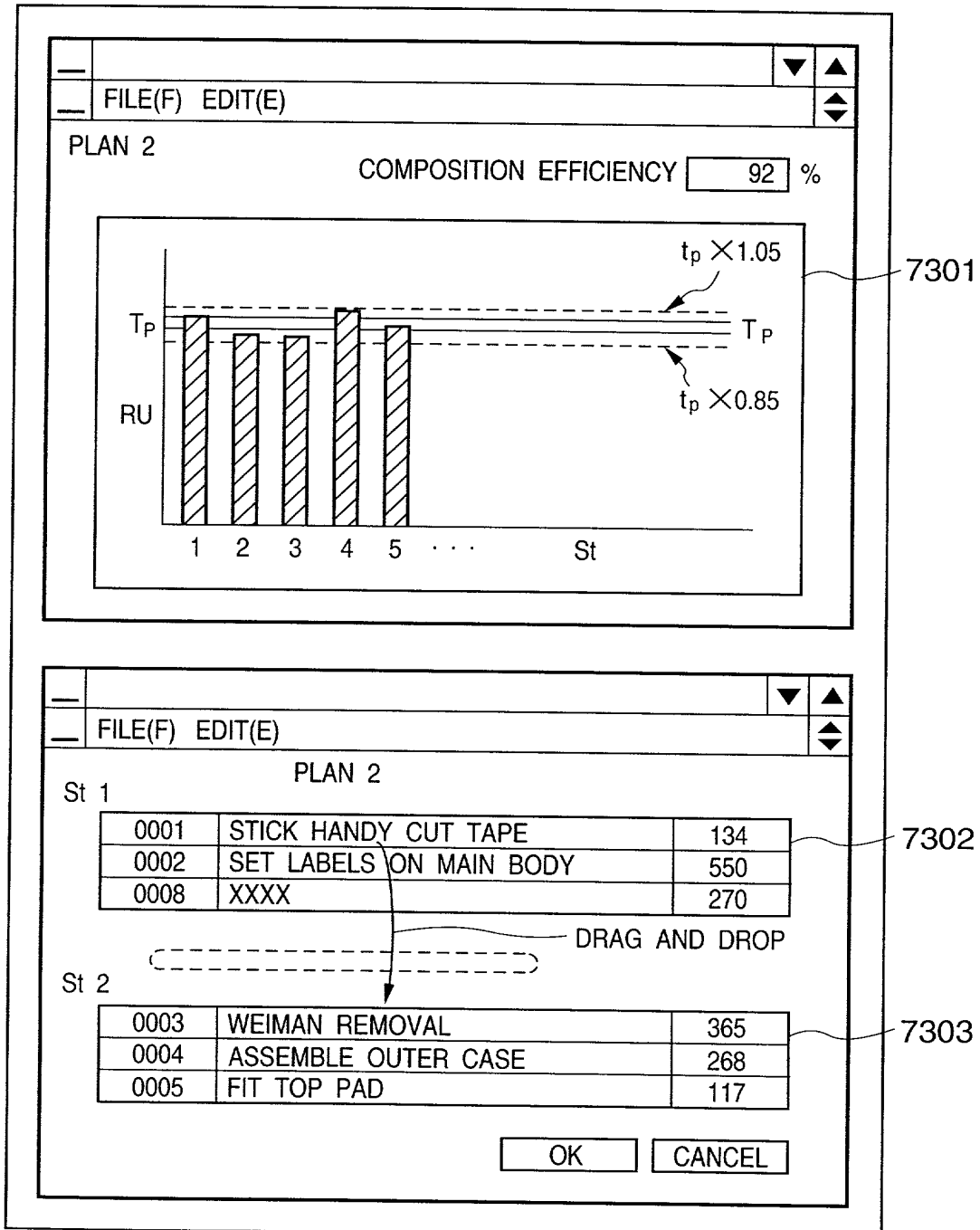


FIG. 74

74/97

7403

LOAD OF NEWLY COMPOSED DATA (MANHOUR)

7401

GENRE

7402

BJ
FAX
LBP
NP
STAND

7404

TARGET MODEL

7405

REPRESENTATIVE MODEL

7406

COMPONENT

7407

COMPONENT SYMBOL	COMPONENT NAME	ORDER

7409

OK

CANCEL

7408

FIG. 75

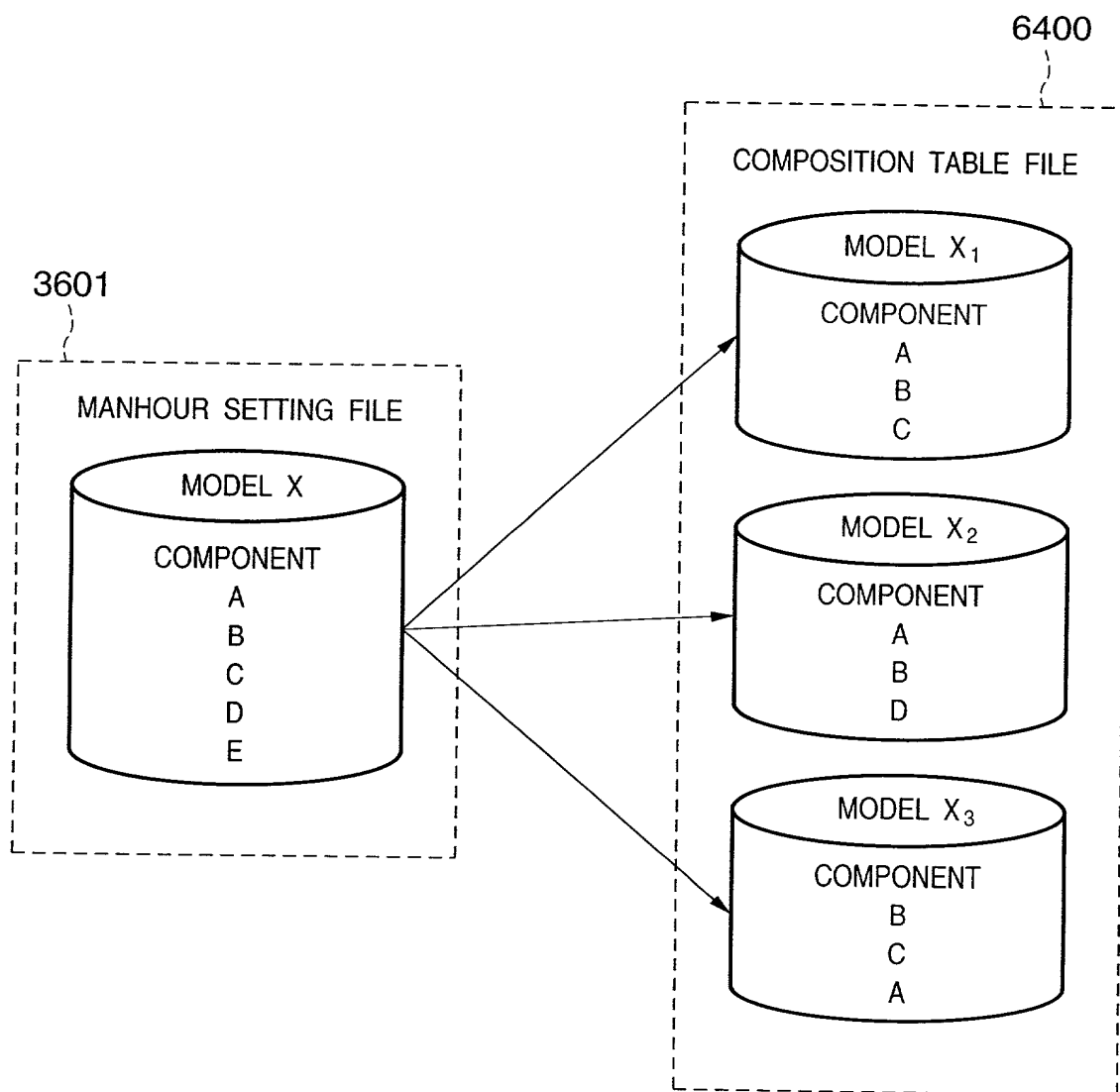


FIG. 76

7601
7602
7603
7604

OPEN FILE

TARGET MODEL

NAME

REVISION NUMBER

SAVE DATE

TEST DATA (ORIGINAL)		
f12-0010.csv	1	97/09/19 12:00:34
f12-0010.csv	0	97/09/19 13:27:17
BJC-4300	0	97/09/19 14:10:14
BJC-4300	0	97/09/19 14:10:32
BJC-4300	1	97/09/19 15:41:14
BJC-4300A LINE FORMATION	03	97/09/20 14:16:58
BJC-4300A LINE FORMATION	00	97/10/13 17:54:57
BJC-4300A LINE FORMATION	05	97/09/20 14:06:36
f12-0010A LINE FORMATION		97/09/24 17:11:53

SELECT WINDOW

☐ COMPOSITION DATA INPUT WINDOW

☐ COMPOSITOR DATA CORRECTION WINDOW

OK

CANCEL

7606

7707 7708 7709 7720 7730

FIG. 78

7801

7802

INSERTION OF UNIT WORK

NEW WORK WILL BE INSERTED BEFORE
"STICK CHECK SHEET SERIAL NO."

INPUT WORK NAME AND PROVISIONAL MANHOUR VALUE

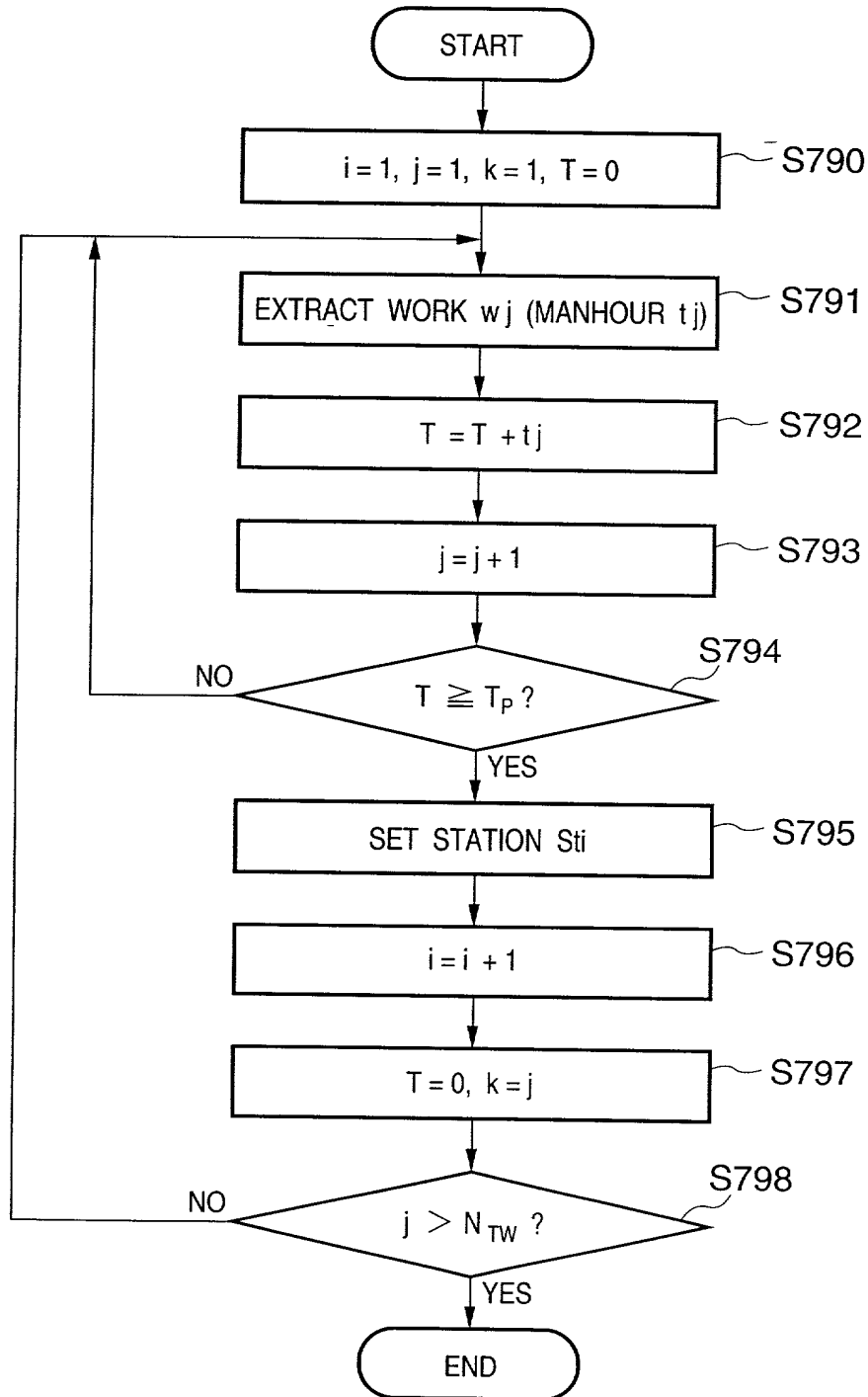
UNIT WORK NAME :

PROVISIONAL MANHOUR : (RU)

REMARKS :

OK CANCEL

FIG. 79



[illegible]

3006

tp
tp*1.05
tp*0.85
t

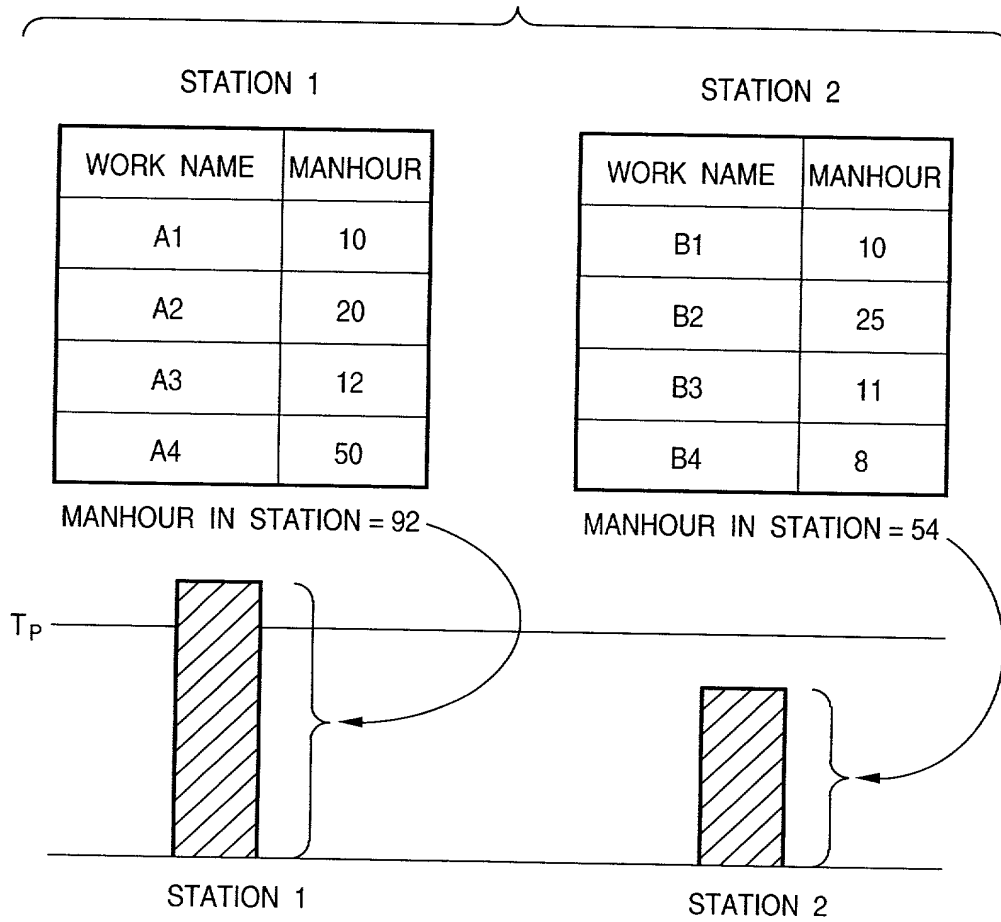
FIG. 81

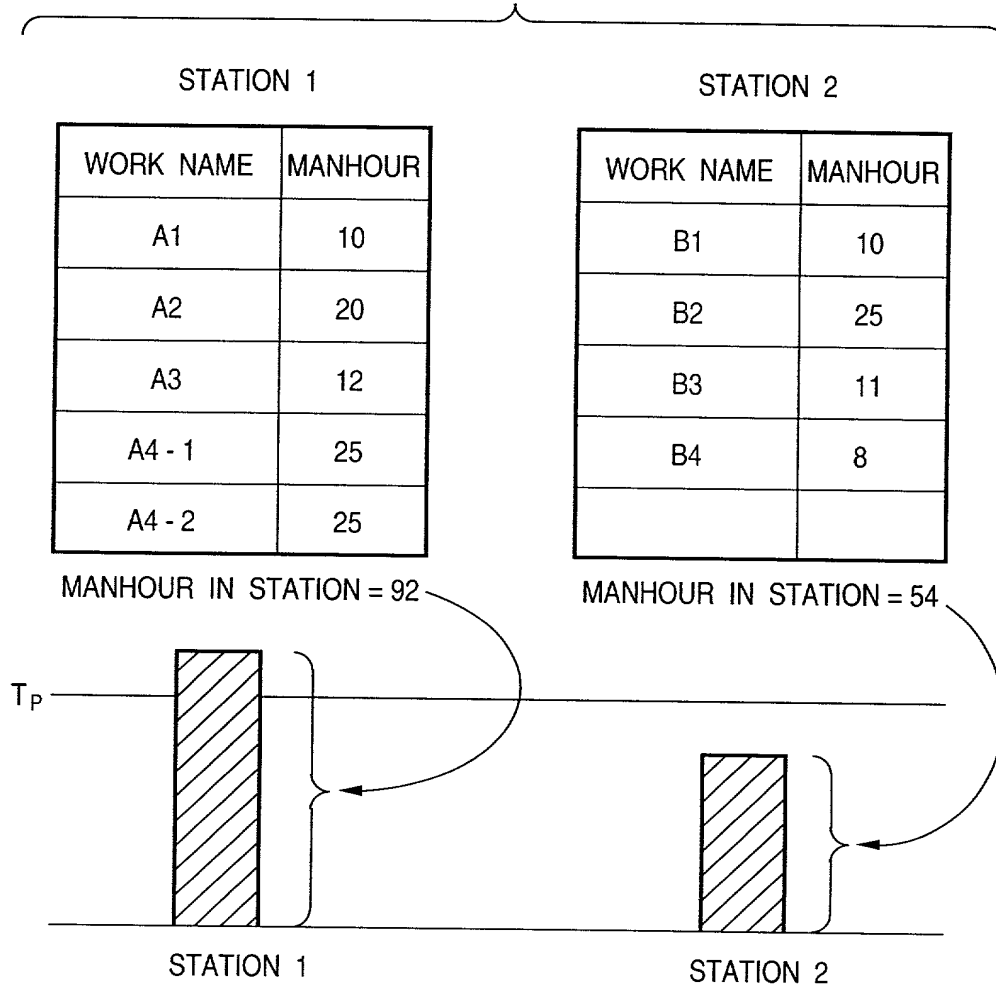
FIG. 82

FIG. 83

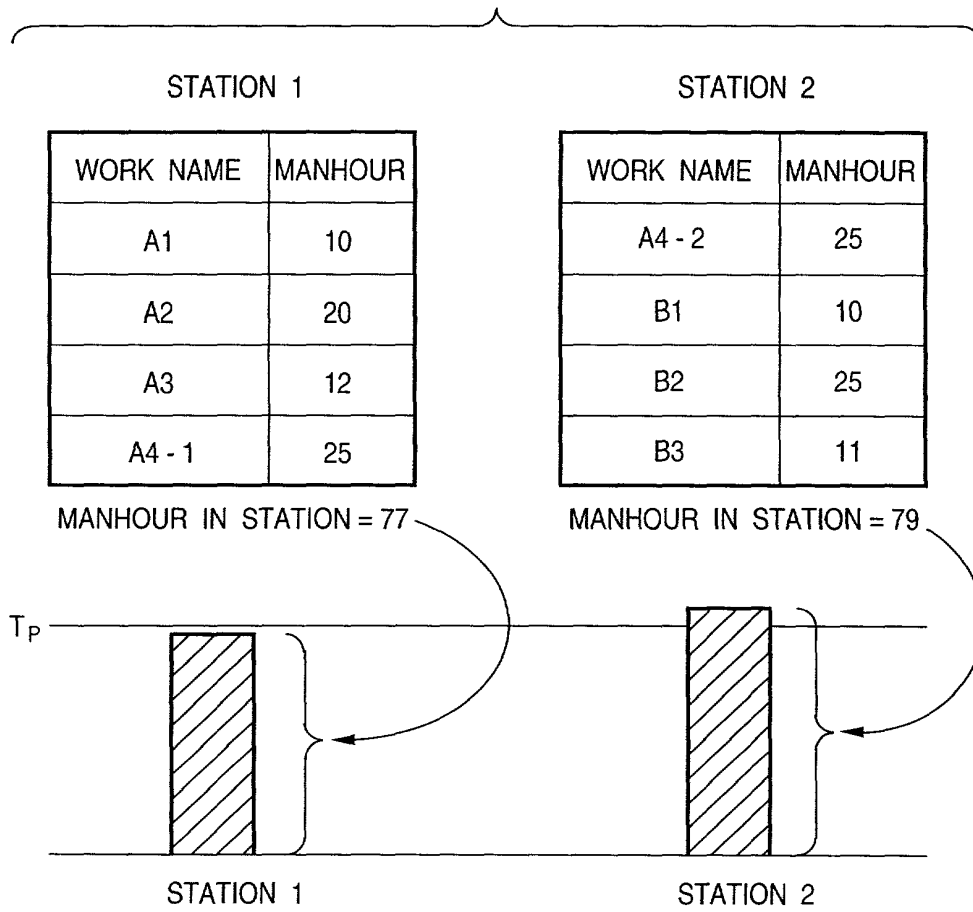


FIG. 84

PARALLEL OPERATION / INTEGRATION OF STATIONS

TARGET STATION : 1

8401

THE NUMBER OF STATIONS

2

8402

OK

CANCEL

FIG. 85

FILE(F) EDIT(E) VIEW(V) TOOL(T)

OPERATOR 1

SI1

WORK NAME	WF	PROV- SIONAL MANHOURL	MA- CHINE UAL
START	0	0	No.
UNIT WORK NAME 1	34	10	No.01
UNIT WORK NAME 2	255	46	No.02
UNIT WORK NAME 3	92	26	No.06
UNIT WORK NAME 4	52	0	No.07
UNIT WORK NAME 5	52	0	No.06
UNIT WORK NAME 6	0	36	No.09

TOTAL 585 (RU) PF 83.6%

OPERATOR 2

SI2

WORK NAME	WF	PROV- SIONAL MANHOURL	MA- CHINE UAL
UNIT WORK NAME 3	156	0	No.03
UNIT WORK NAME 4	34	0	No.04
UNIT WORK NAME 5	138	23	No.06
UNIT WORK NAME 10	71	48	No.10
UNIT WORK NAME 11	138	30	No.11
UNIT WORK NAME 12	97	20	No.12
UNIT WORK NAME 13	88	0	No.14
UNIT WORK NAME 14	46	18	No.15
UNIT WORK NAME 15	546	15	No.16
UNIT WORK NAME 16	58	20	No.17

TOTAL 1548 (RU) xxxxxx PF 23.5 %

OPERATOR 3

SI3

WORK NAME	WF	PROV- SIONAL MANHOURL	MA- CHINE UAL
UNIT WORK NAME 13	30	40	No.13
UNIT WORK NAME 16	303	131	No.18

TOTAL 572 (RU) PF 96.7%

OPERATOR 4

SI4

WORK NAME	WF	PROV- SIONAL MANHOURL	MA- CHINE UAL
UNIT WORK NAME 19	84	26	No.19
UNIT WORK NAME 20	120	20	No.20
UNIT WORK NAME 21	310	66	No.21

TOTAL 623 (RU) PF 95.2%

OPERATOR 5

SI5

WORK NAME	WF	PROV- SIONAL MANHOURL	MA- CHINE UAL
UNIT WORK NAME 22	146	71	No.22
UNIT WORK NAME 23	106	26	No.23
UNIT WORK NAME 24	61	0	No.24
UNIT WORK NAME 25	51	10	No.25
END	0	0	No.X

TOTAL 486 (RU) PF 73.6%

PARALLEL STATIONS

900
720
540
360
180
0

1 2 3 4 5

G STANDARD NO. WORK NAME

PROVISIONAL REMARKS

COMPOSITION MODE: PRIORITY ORDER SCHEME

COMPOSITION EFFICIENCY % 116

NET COMPOSITION EFFICIENCY %

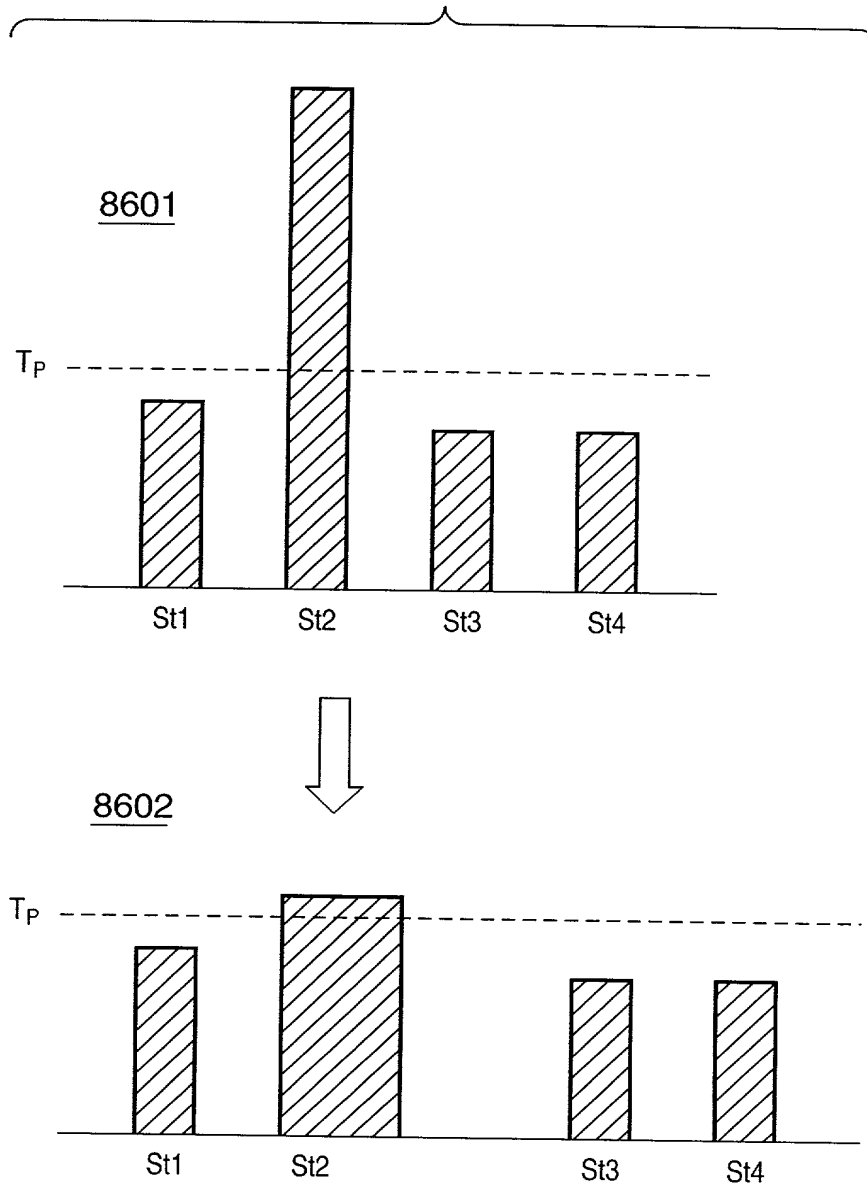
FIG. 86

FIG. 87

USER REGISTRATION

NAME CODE : 12345 8701

NAME : TANAKA ICHIRO 8702

POSITION : kumitate 8703

PASSWORD : 12345 8704

AUTHORITY : 8705

OK CANCEL

FIG. 88

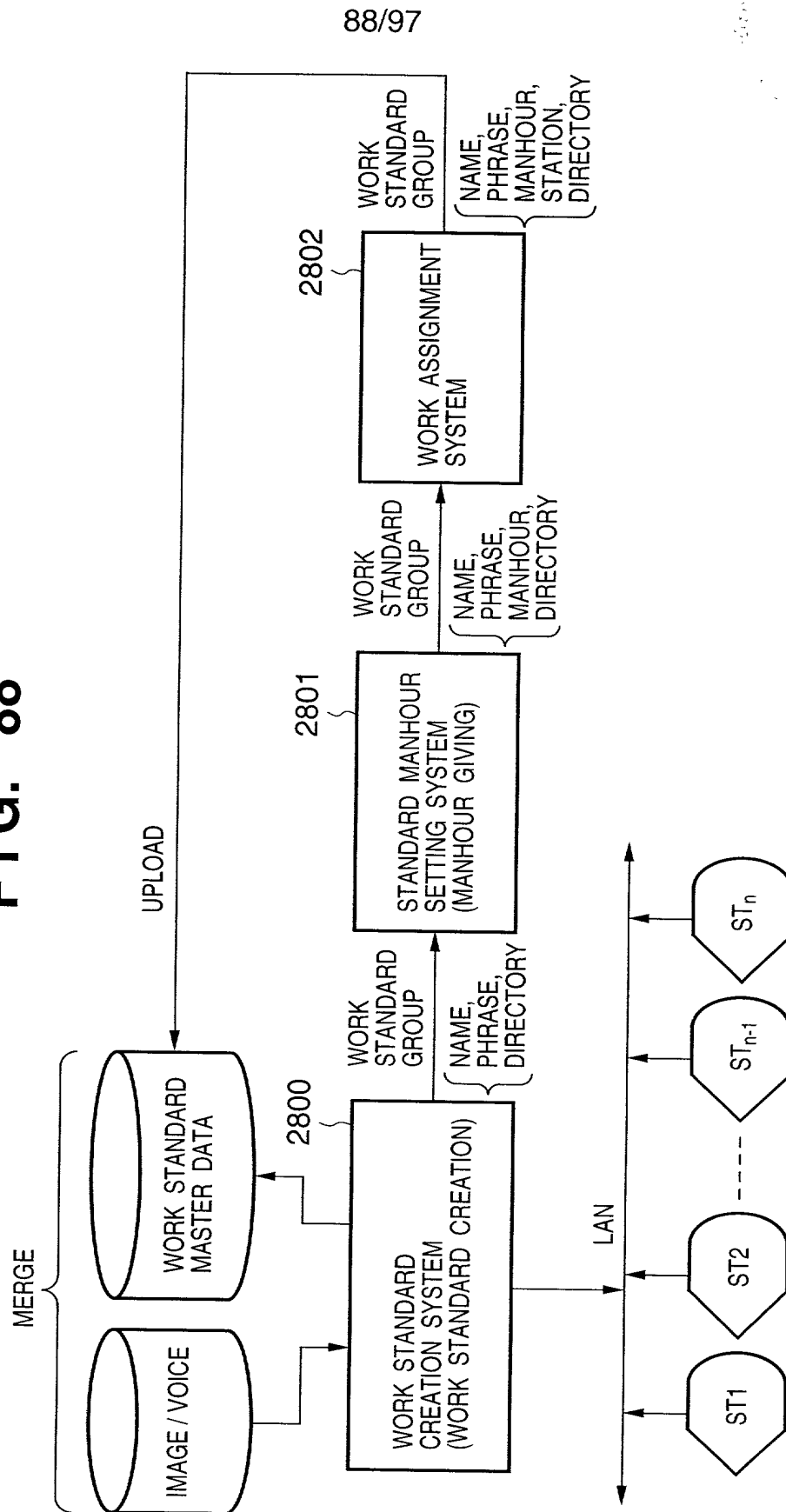


FIG. 89

DIRECTORY NAME	IMAGE DATA	OPERATION (VERB)	PARAMETER 1	PARAMETER 2	PARAMETER 3
xxxxx1	SCREW	SCREW	SCREW CLOCKWISE	DISTANCE MOVEMENT 10mm	TORQUE 10Kg.M
xxxxx2	SCREW	SCREW	SCREW CLOCKWISE	DISTANCE MOVEMENT 20mm	TORQUE 20Kg.M
xxxxx3	SCREW	SCREW	SCREW CLOCKWISE	DISTANCE MOVEMENT 20mm	TORQUE 30Kg.M
...
yyyyy1	ROTATE	ROTATE	CLOCKWISE	DISTANCE MOVEMENT 20mm	
yyyyy2	ROTATE	ROTATE	COUNTERCLOCKWISE	DISTANCE MOVEMENT 20mm	
...
zzzzz1	OPEN	OPEN	OPEN UPWARD	DISTANCE MOVEMENT 30mm	WEIGHT 100g
zzzzz2	OPEN	OPEN	OPEN DOWNWARD	DISTANCE MOVEMENT 40mm	WEIGHT 200g
...

FIG. 90

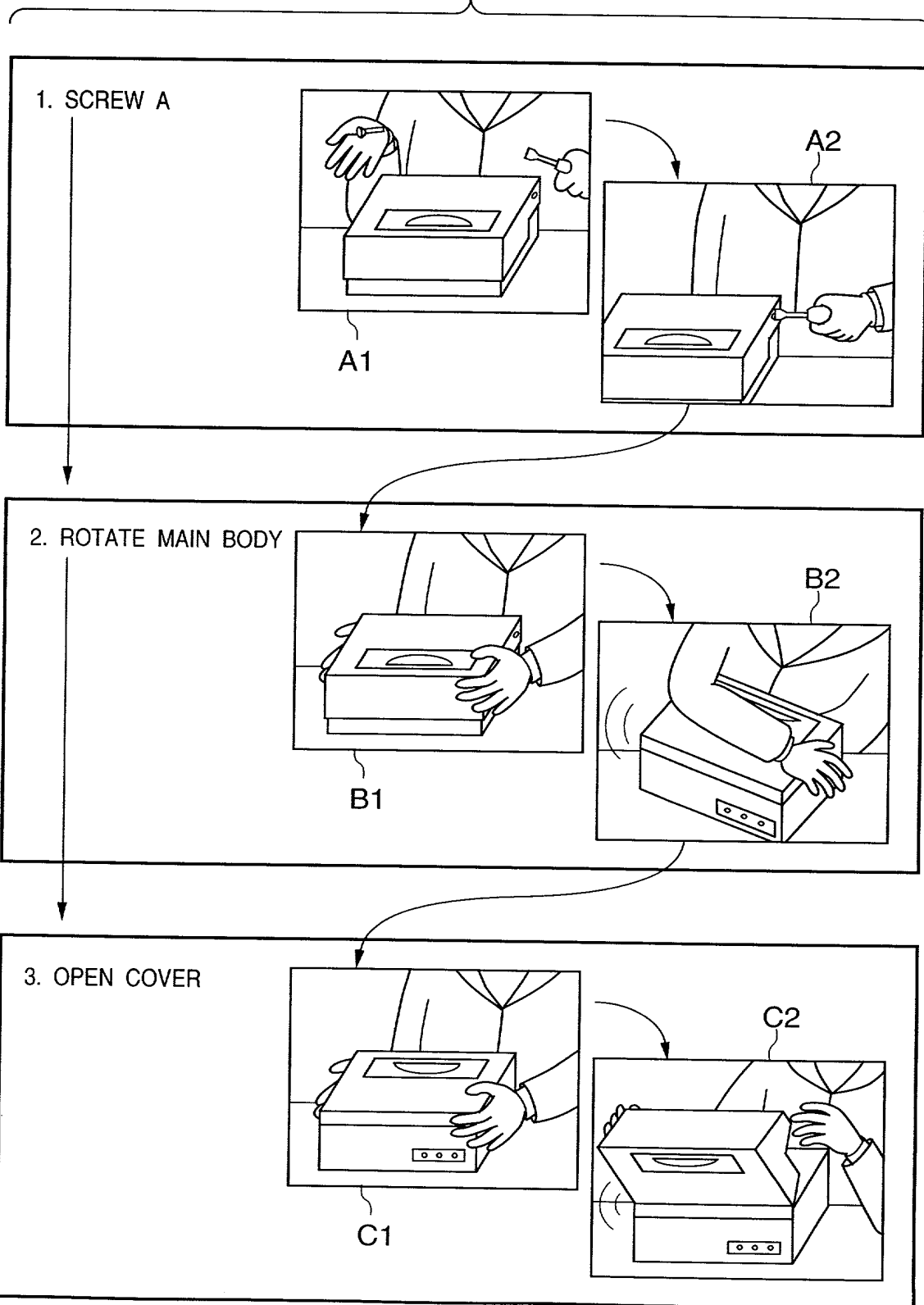


FIG. 91

9101 9102

SETTING OF COMPONENT SYMBOL

PRODUCT SYMBOL : BJ - 970909

COMPONENT SYMBOL : CH

COMPONENT NAME : CHECK

OK SEARCH COMPONENT CANCEL

FIG. 92

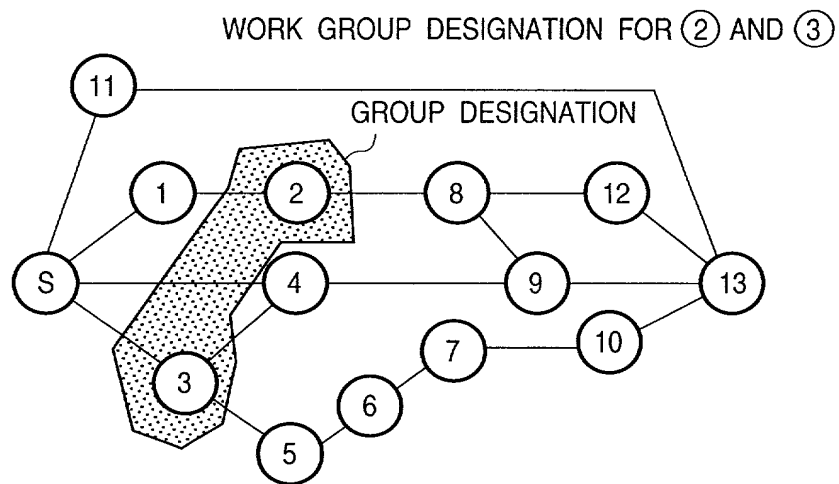


FIG. 93

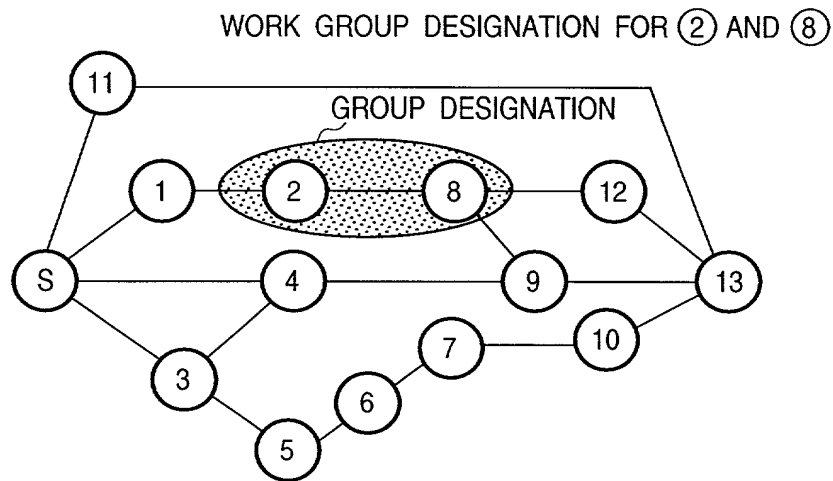
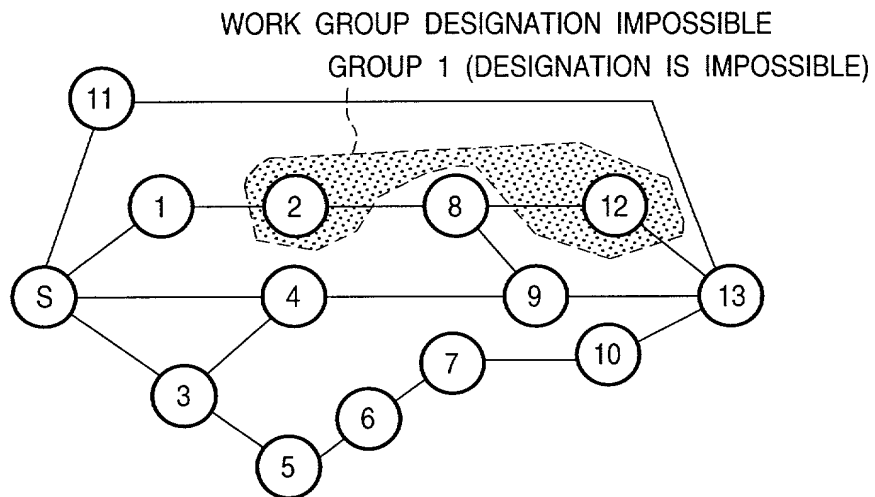
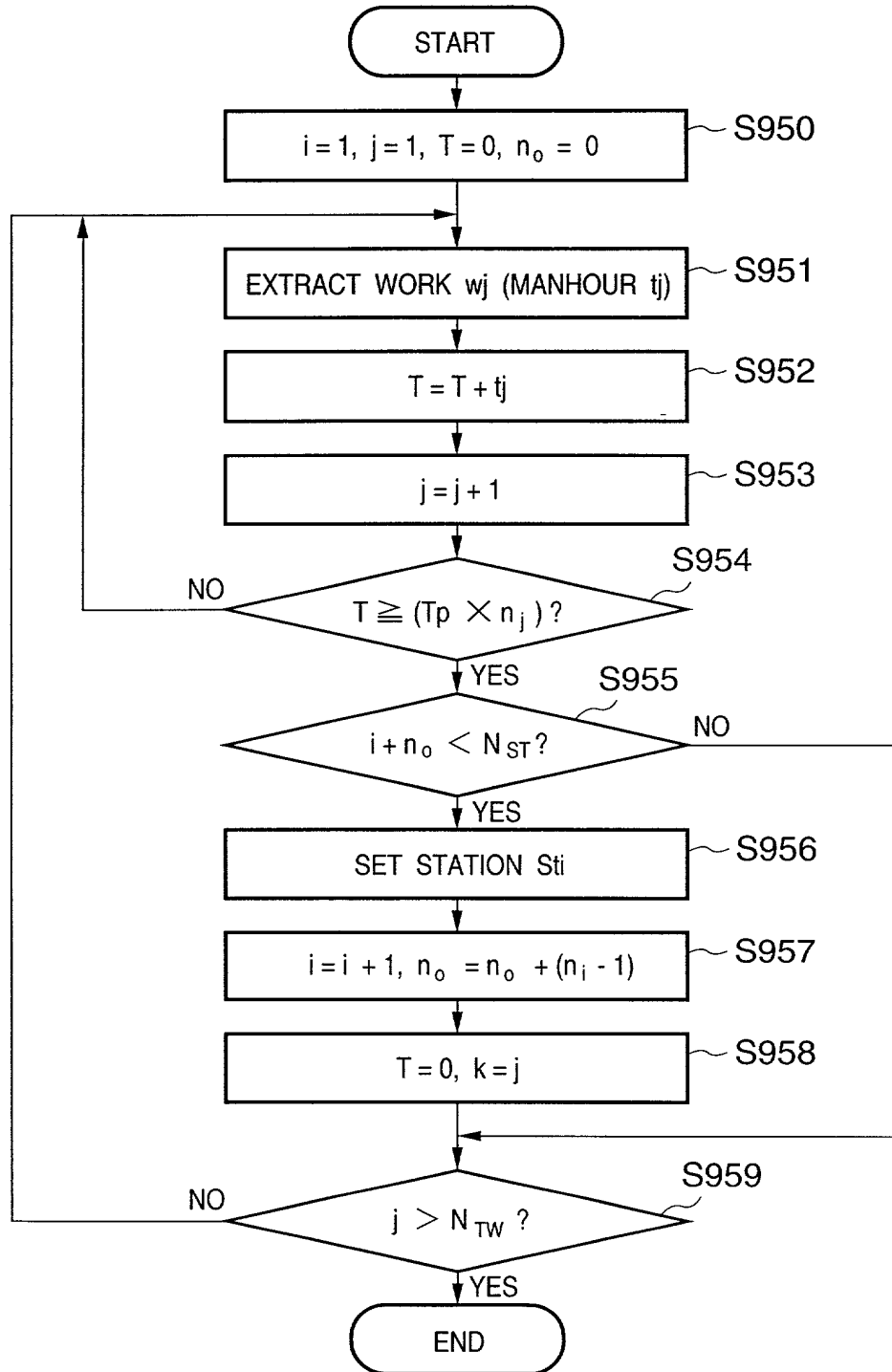


FIG. 94

95/97

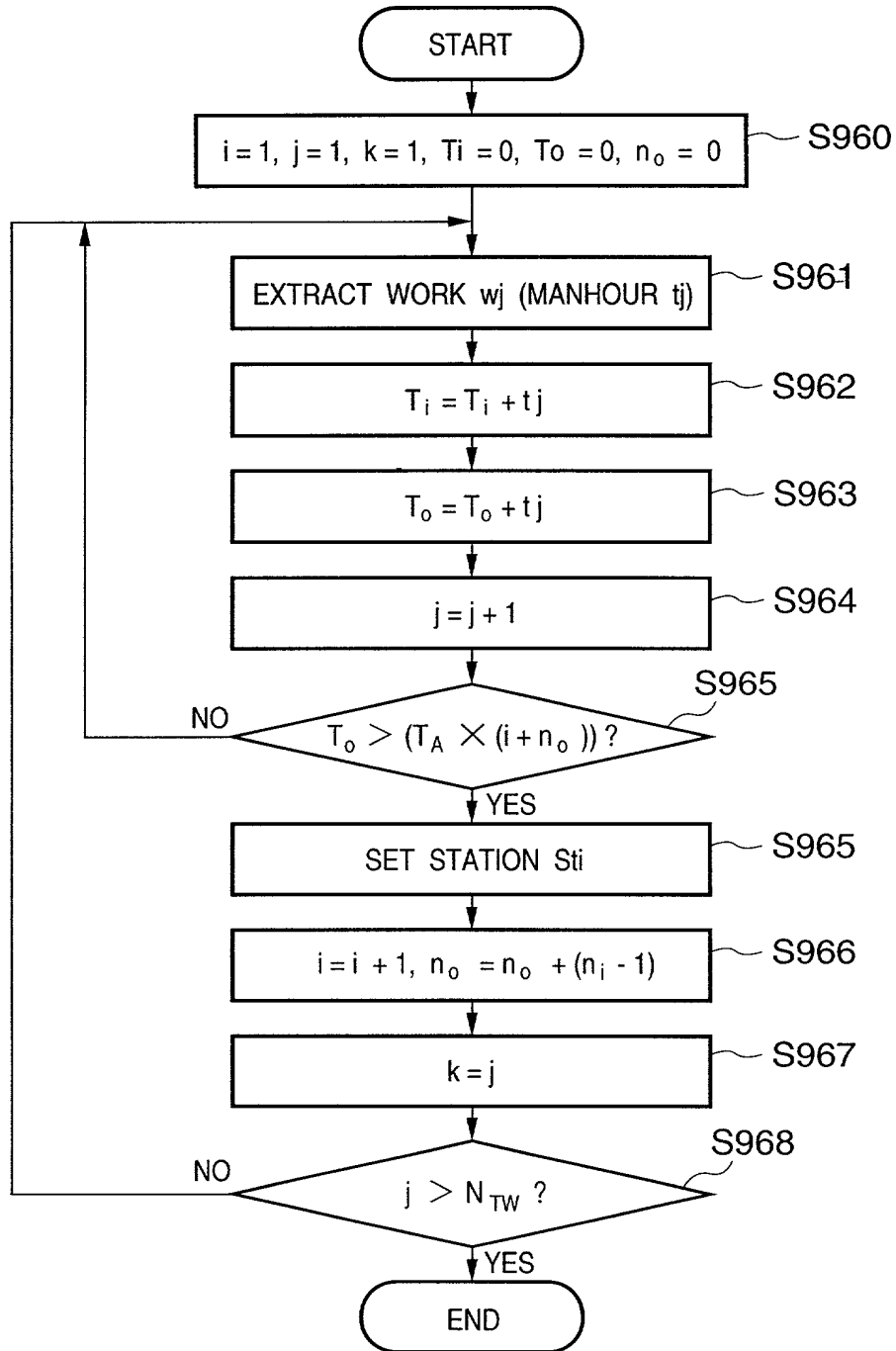
FIG. 95



N_{ST} : THE NUMBER OF STATIONS
 n_i : i STATION PARALLEL NUMBER
 n_o : TOTAL ACCUMULATED PARALLEL SUM NUMBER

96/97

FIG. 96



N_{ST} : THE NUMBER OF STATIONS

T_i : i STATION MANHOUR

T_A : STATION MANHOUR AVERAGE VALUE

$T_A = WF / N_{ST}$

T_o : TOTAL ACCUMULATED MANHOUR

n_i : i STATION PARALLEL NUMBER

n_o : TOTAL ACCUMULATED PARALLEL SUM NUMBER

FIG. 97

FILE(E) EDIT(E) VIEW(D) TOOL(I)

OPERATOR 1

WORK NAME	WF	PROV. SIONAL MANHOUR	MA-CHINE UAL
START	0	0	No
UNIT WORK NAME 1	34	10	No 01
UNIT WORK NAME 2	255	46	No 02
UNIT WORK NAME 6	92	26	No 06
UNIT WORK NAME 7	52	0	No 07
UNIT WORK NAME 8	52	0	No 08
UNIT WORK NAME 9	0	36	No 09

TOTAL 585 (RU)

OPERATOR 2

WORK NAME	WF	PROV. SIONAL MANHOUR	MA-CHINE UAL
UNIT WORK NAME 3	156	0	No 03
UNIT WORK NAME 4	34	0	No 04
UNIT WORK NAME 5	138	23	No 06
UNIT WORK NAME 10	71	48	No 10
UNIT WORK NAME 11	138	30	No 11
UNIT WORK NAME 12	97	20	No 12
UNIT WORK NAME 13	88	0	No 14
UNIT WORK NAME 14	46	18	No 15
UNIT WORK NAME 15	546	15	No 16
UNIT WORK NAME 16	58	20	No 17

TOTAL 1548 (RU) xxxxxx

OPERATOR 3

WORK NAME	WF	PROV. SIONAL MANHOUR	MA-CHINE UAL
UNIT WORK NAME 13	30	40	No 13
UNIT WORK NAME 16	303	131	No 18

TOTAL 572 (RU)

OPERATOR 4

WORK NAME	WF	PROV. SIONAL MANHOUR	MA-CHINE UAL
UNIT WORK NAME 19	84	26	No 19
UNIT WORK NAME 20	120	20	No 20
UNIT WORK NAME 21	310	66	No 21

TOTAL 6238 (RU)

OPERATOR 5

WORK NAME	WF	PROV. SIONAL MANHOUR	MA-CHINE UAL
UNIT WORK NAME 22	146	71	No 22
UNIT WORK NAME 23	106	26	No 23
UNIT WORK NAME 24	61	0	No 24
UNIT WORK NAME 25	51	10	No 25
END	0	0	No X

TOTAL 486 (RU)

OPERATOR 6

WORK NAME	WF	PROV. SIONAL MANHOUR	MA-CHINE UAL
UNIT WORK NAME 22	146	71	No 22
UNIT WORK NAME 23	106	26	No 23
UNIT WORK NAME 24	61	0	No 24
UNIT WORK NAME 25	51	10	No 25
END	0	0	No X

TOTAL 486 (RU)

PF 83.6% PARALLEL STATIONS PF 117.3%

PARALLEL STATIONS

STATION	WORK NAME	WF	MA-CHINE	PROV. SIONAL MANHOUR	REMARKS
1					
2					
3					
4					
5					

G STANDARD NO. WORK NAME

COMPOSITION MODE: PRIORITY ORDER SCHEME

COMPOSITION EFFICIENCY 96.43 %

NET COMPOSITION EFFICIENCY %